

FIG. 1

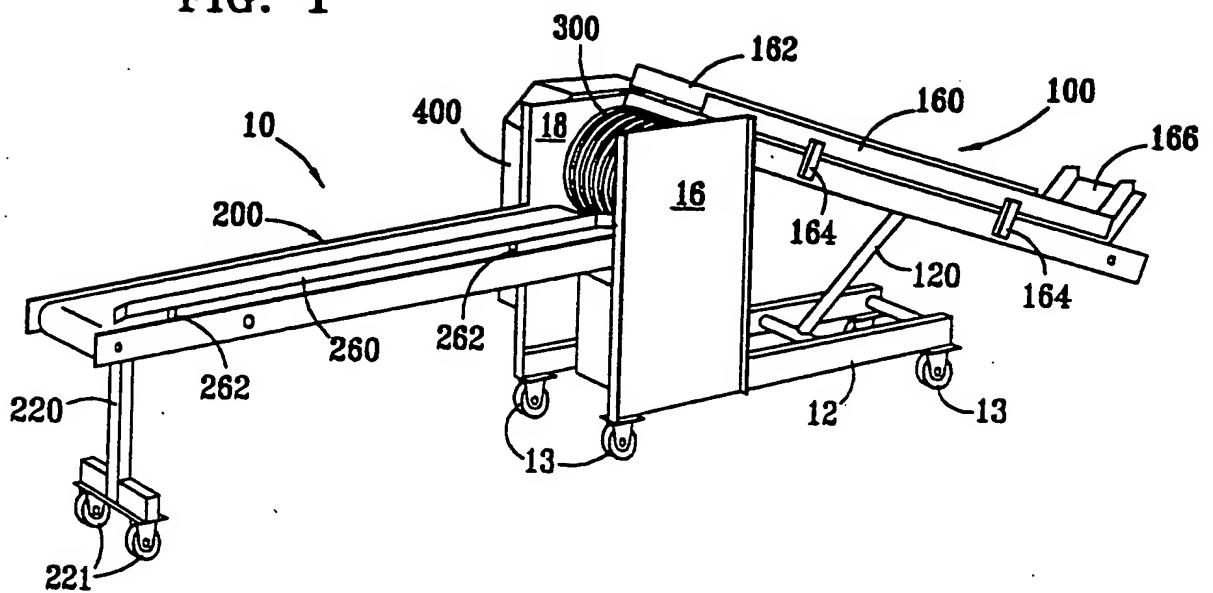


FIG. 2

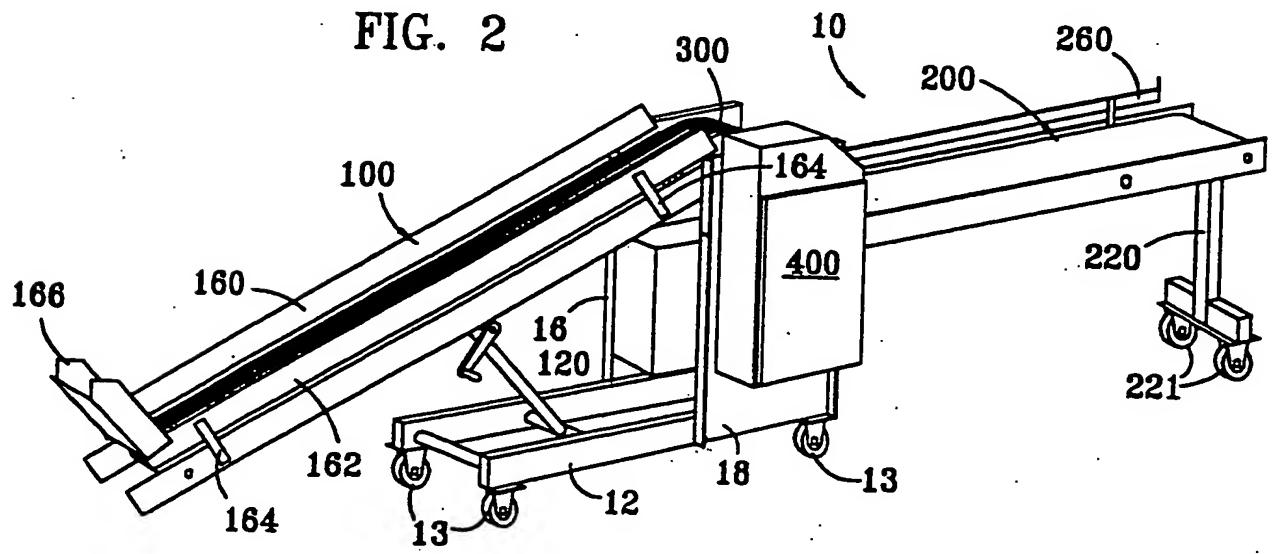


FIG. 3

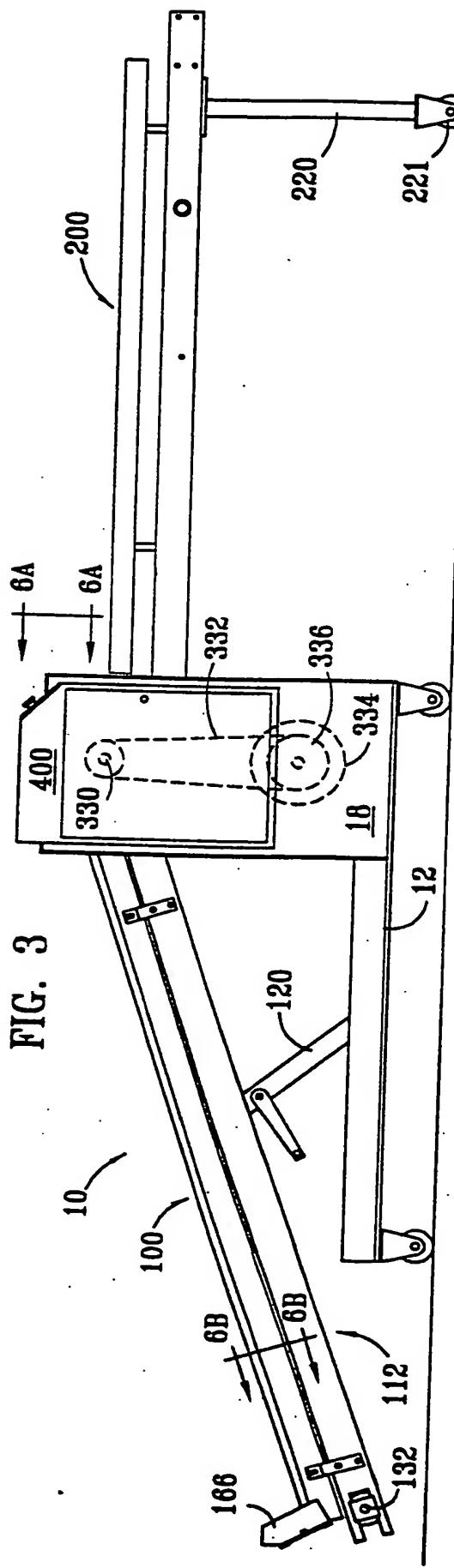


FIG. 6A

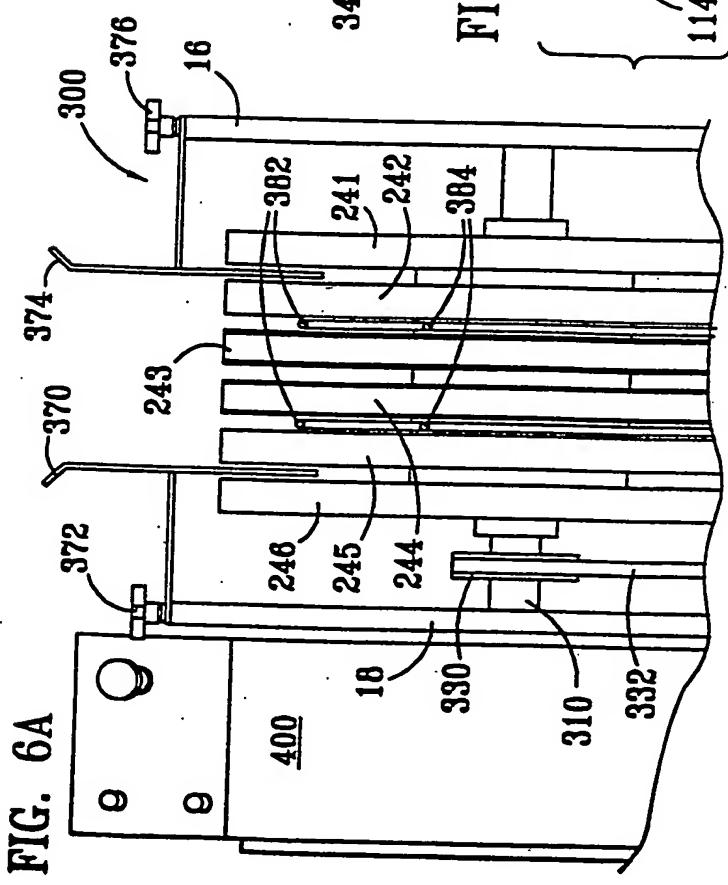


FIG. 7A

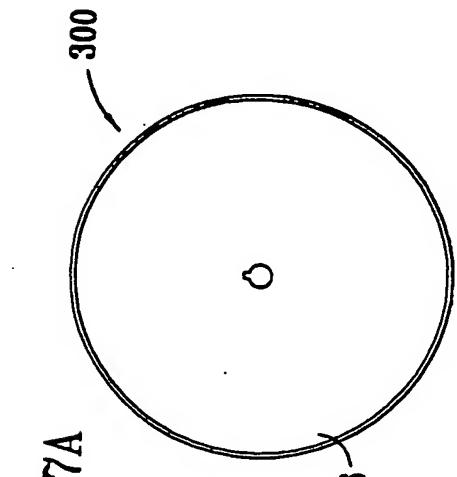
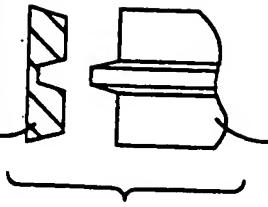


FIG. 7B
144,142,145,146



341,342,345,346

FIG. 6B

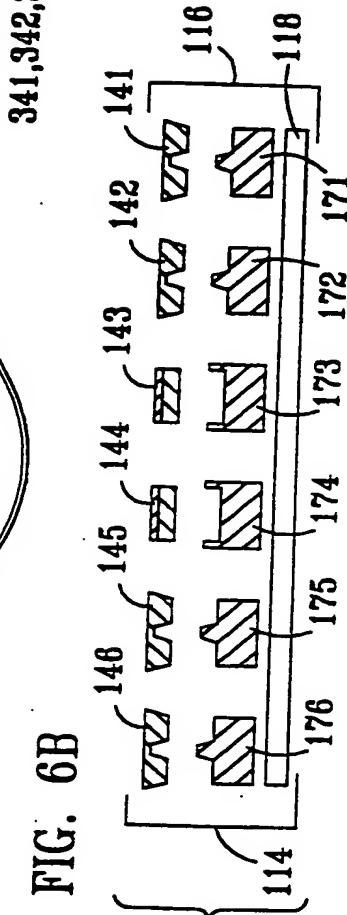


FIG. 4

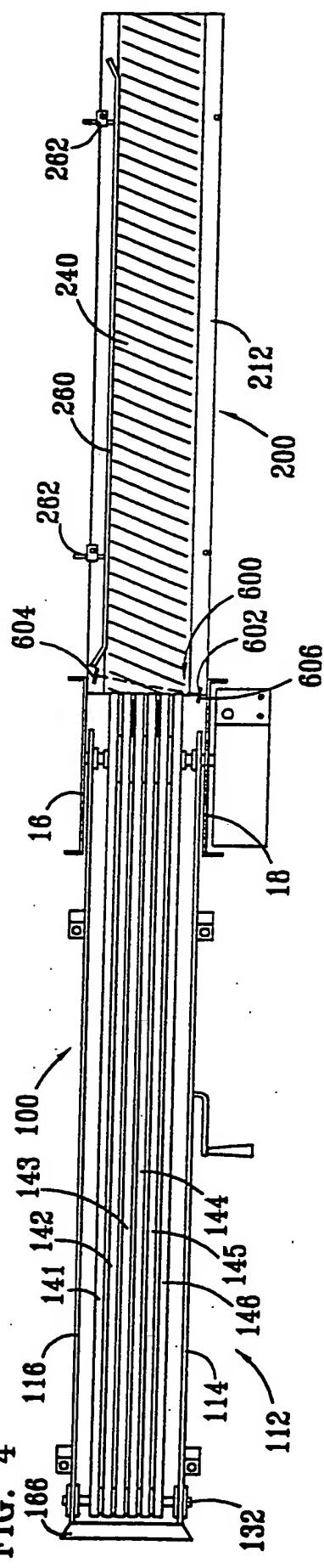
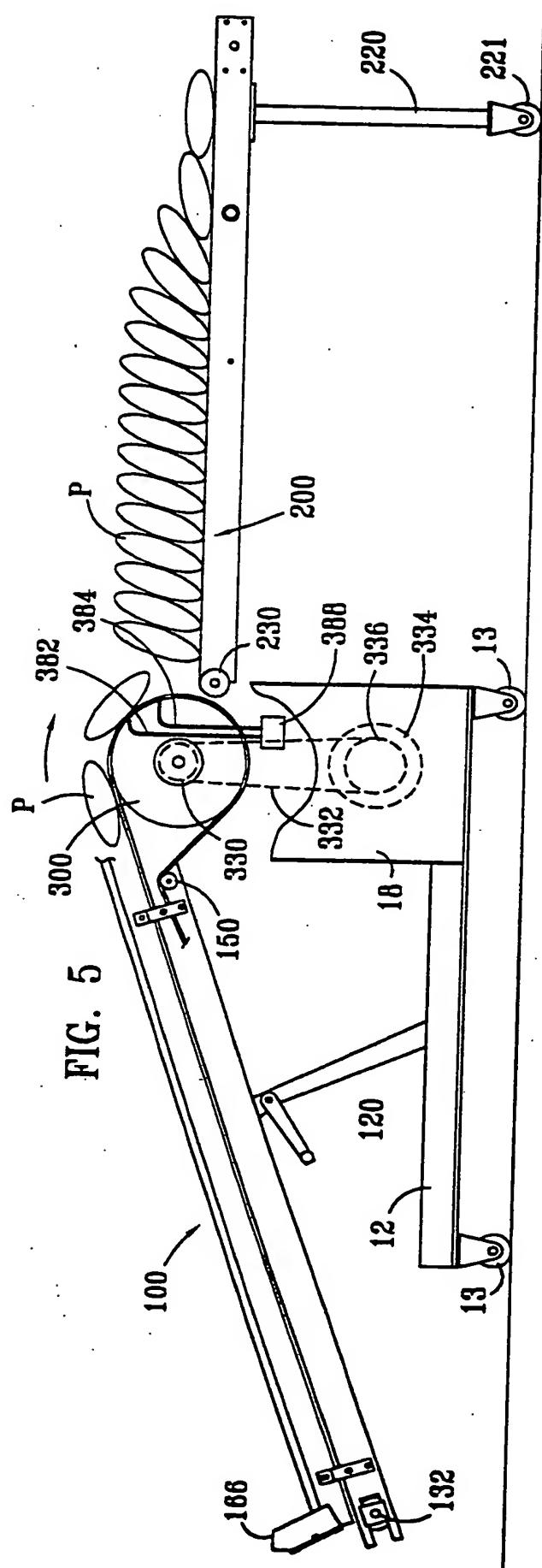


FIG. 5



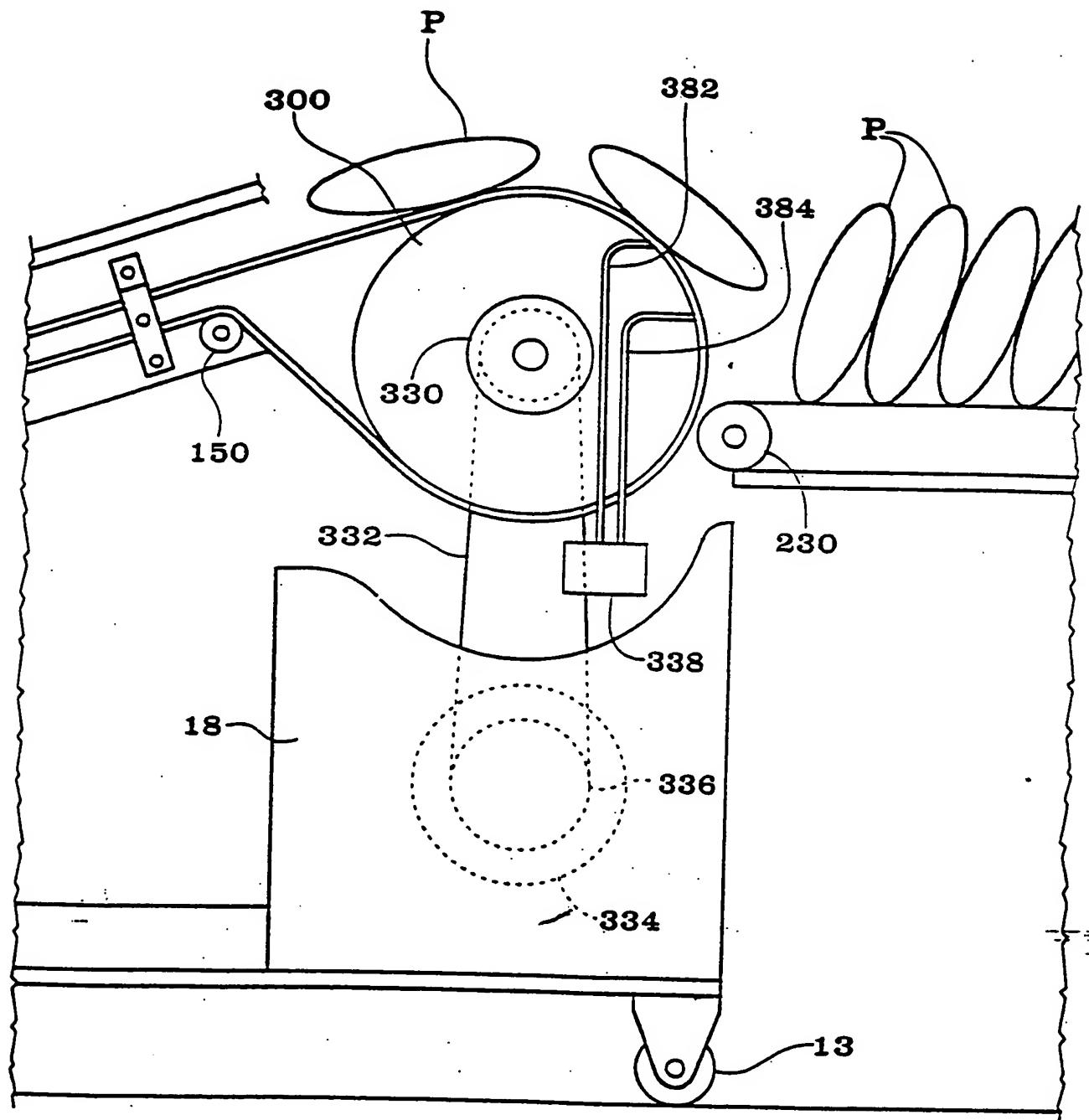


FIG.5A

FIG. 7C

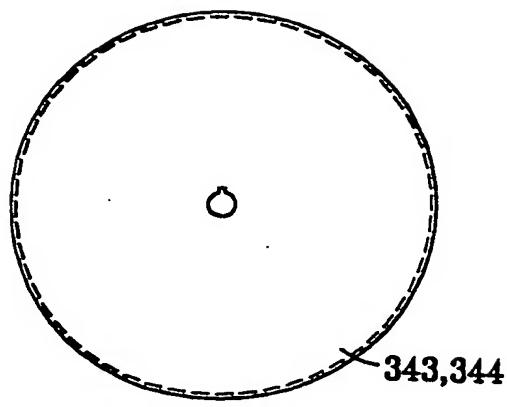


FIG. 7D

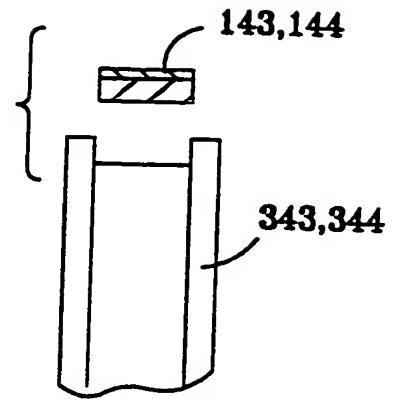


FIG. 8A

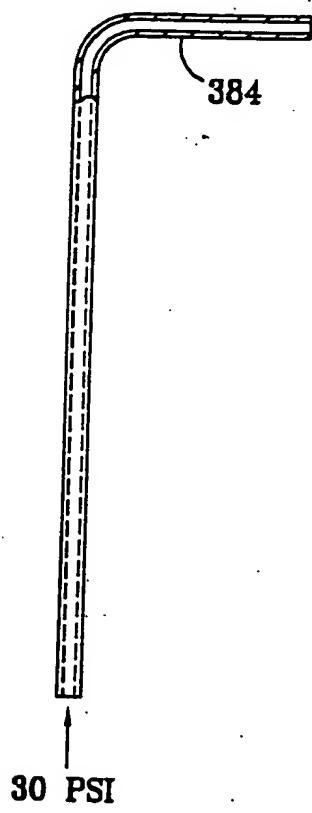


FIG. 8B

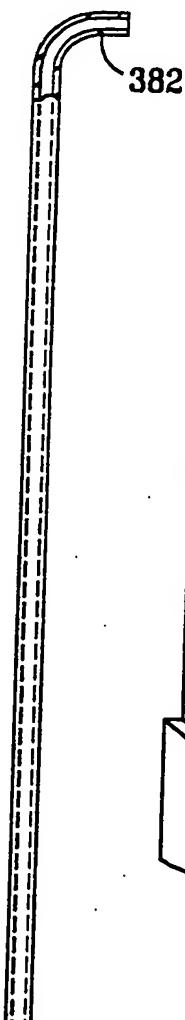


FIG. 9

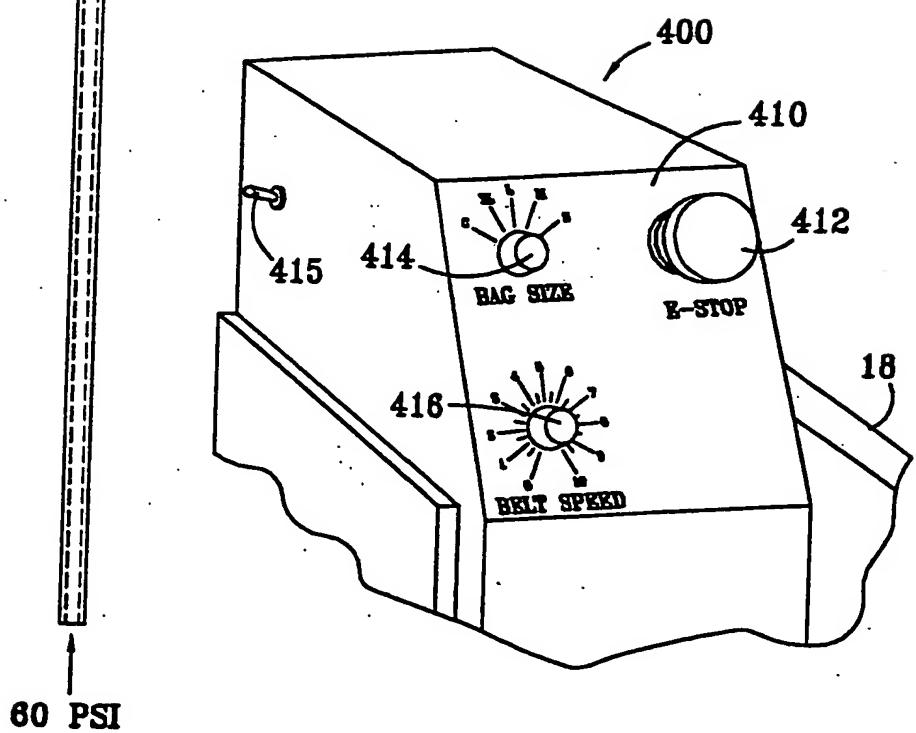


FIG. 10

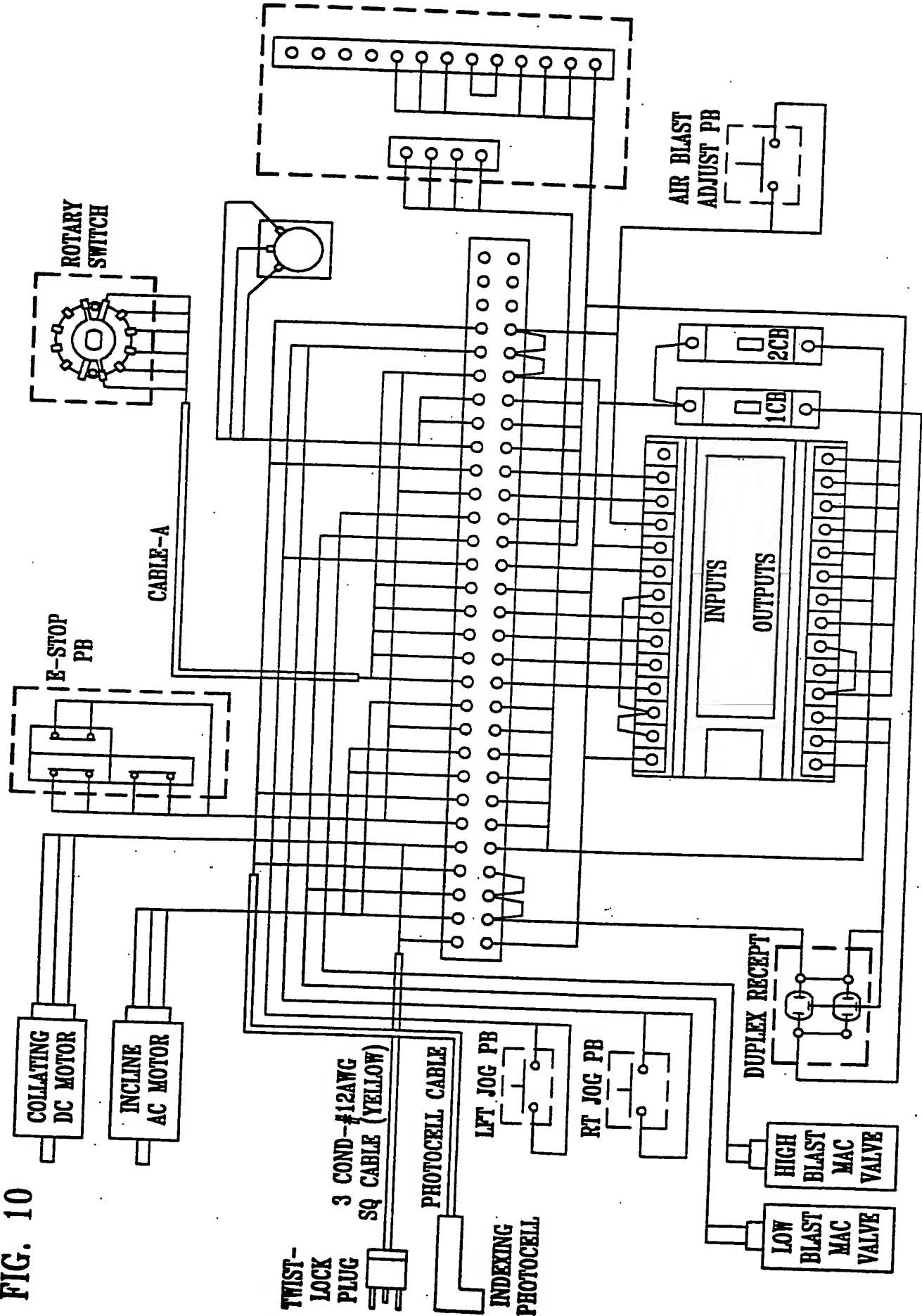


FIG. 11A

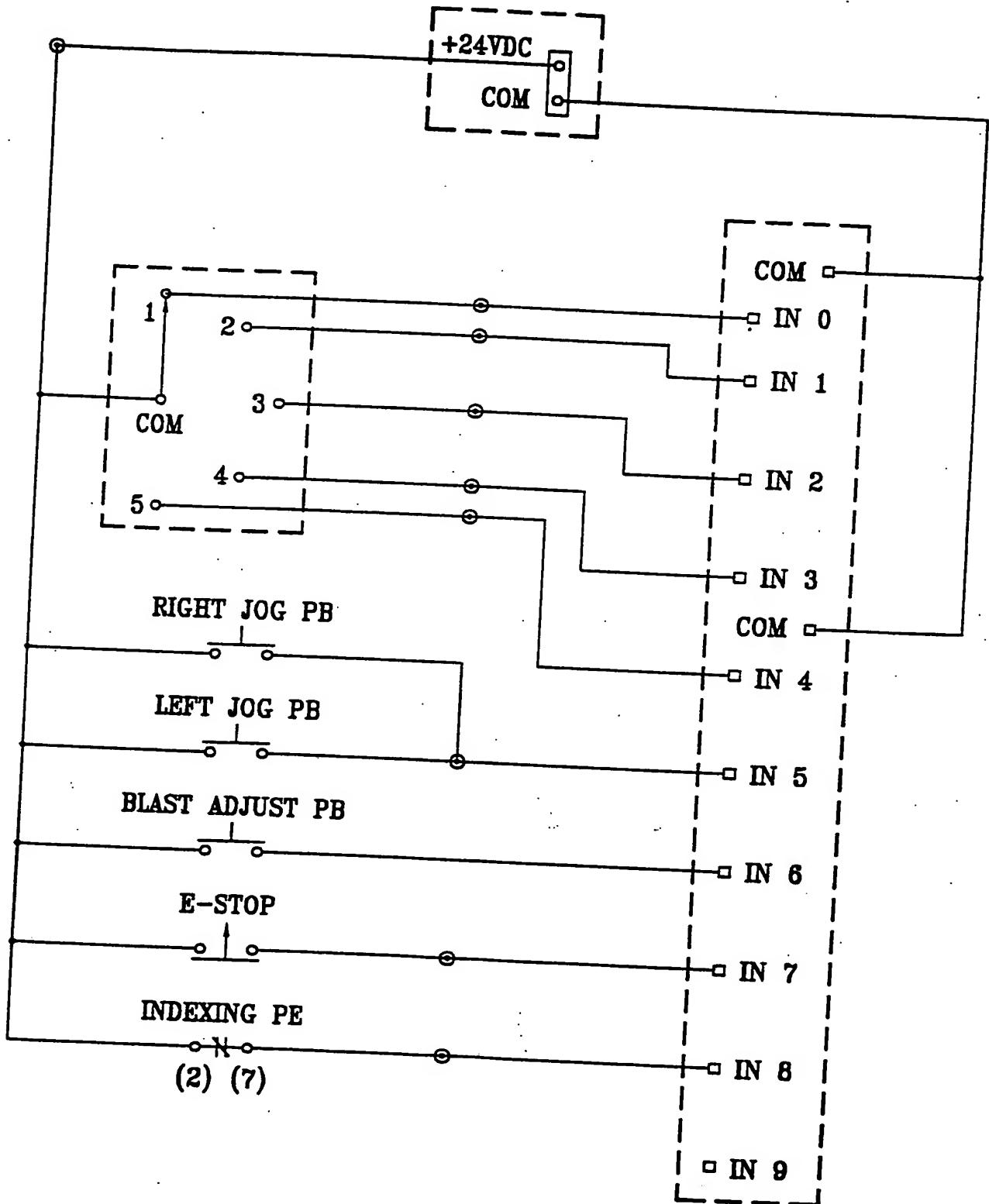
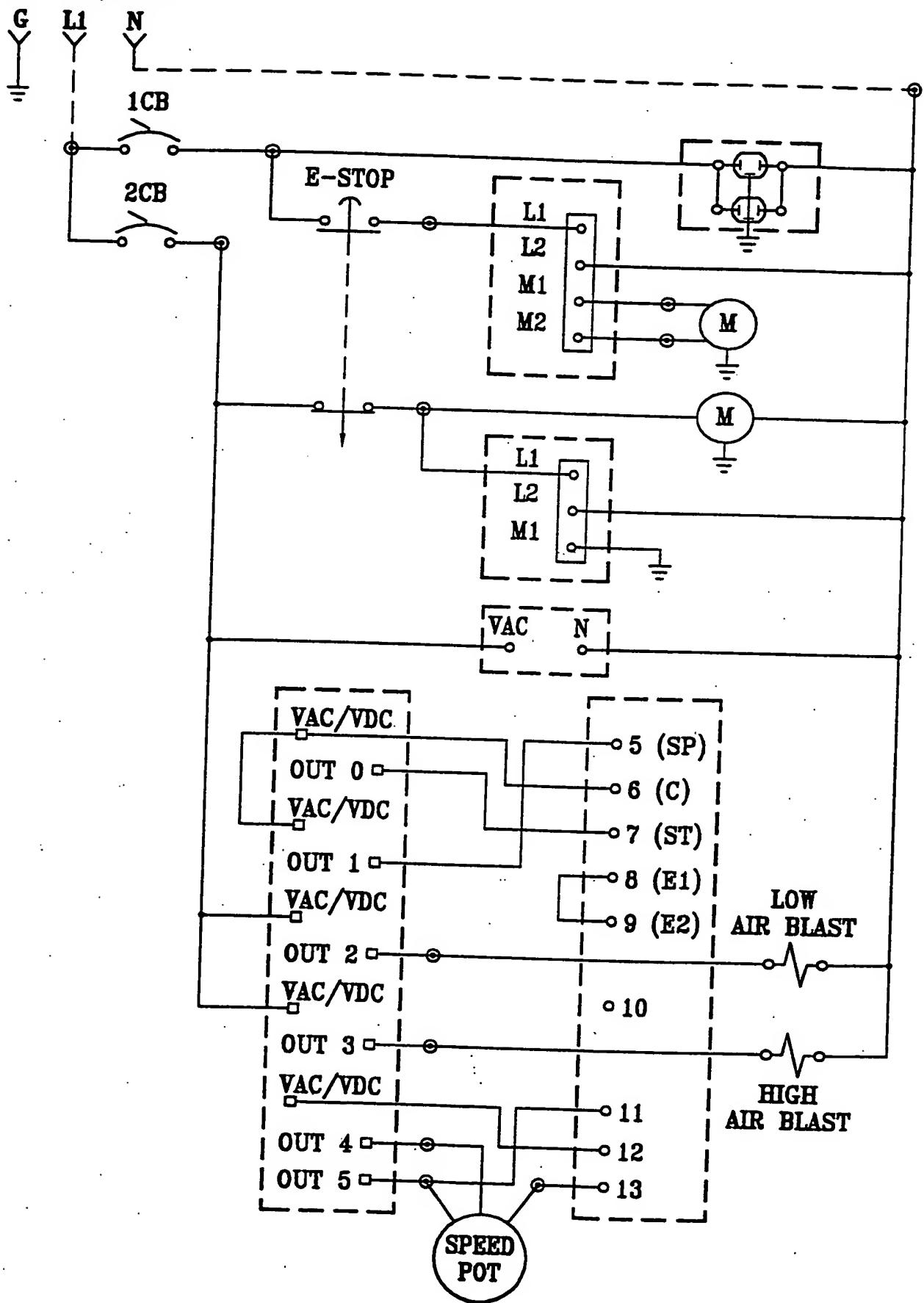


FIG. 11B

120V, 1PH, 60Hz



AIR ASSISTED COLLATOR PROGRAM LISTING

Rung 2:3

The diagram illustrates a timing sequence starting with a 'Rotary Sw' event at time 0. This triggers a 'Blast Enable Tmr' at time T4:4. The timer begins its cycle, indicated by a vertical line between two dashed horizontal lines. The timer's output, 'Small Low Blast Tmr', is shown as a pulse starting at T4:2 and ending at T4:4. The timer's internal state is detailed on the right, showing 'Time Base' (0.01), 'Preset' (20), and 'Accum' (0).

Rung 2:4

Timing diagram illustrating the sequence of events for a blast timer:

- Rotary Sw**: Med. Bag I:0
- Blast Enable Tmr**: T4:4
- Med. Low Blast Tmr**: T4:5+(DN)
- Timer**: T4:5+(DN)
- Time Base**: 0.01
- Preset**: 26
- Accum**: 0

The diagram shows the following sequence of logic levels over time:

- Initial state: All lines low.
- Step 1: Rotary Sw goes high (I:0).
- Step 2: Med. Bag enable goes high.
- Step 3: Timer enable goes high (T4:4).
- Step 4: Timer starts (T4:5+(DN)).
- Step 5: Timer output goes high.
- Step 6: Med. Low Blast Tmr goes high (T4:5+(DN)).
- Step 7: Timer stops (T4:5+(DN)).
- Step 8: Timer output goes low.
- Step 9: Med. Low Blast Tmr goes low (T4:5+(DN)).

Rung 2:5

```

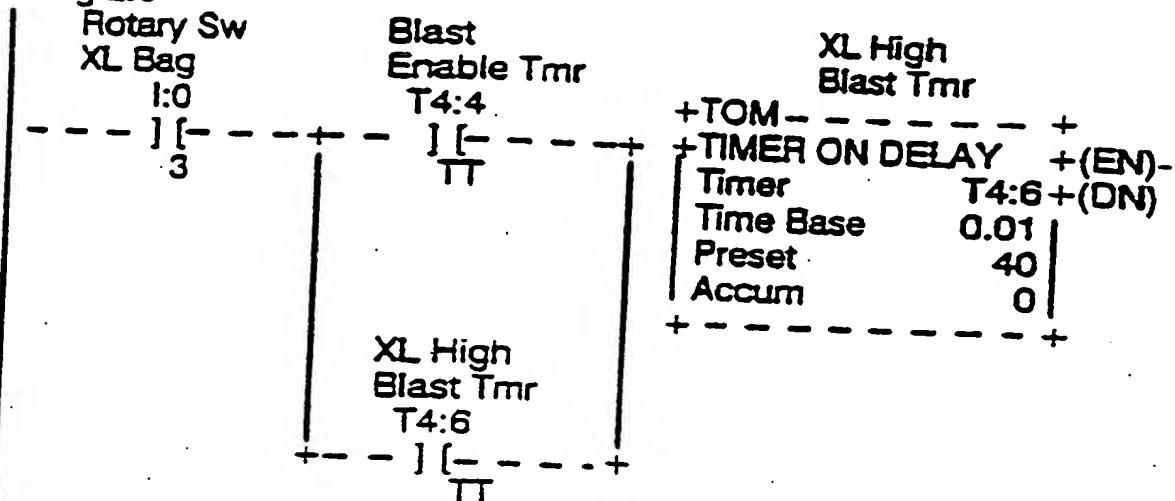
graph LR
    LB[Large Bag] -- I:0 --> BE[Enable Tmr  
T4:4]
    BE --> LHT[Large High Blast Tmr  
T4:3]
    BE --> T[Timer]
    T --> TB[Time Base  
0.01]
    T --> P[Preset  
30]
    T --> A[Accum  
0]
    A --> S[Sum]
    LHT --> S
    style S fill:none,stroke:none
    style LHT fill:none,stroke:none
    style T fill:none,stroke:none
    style TB fill:none,stroke:none
    style P fill:none,stroke:none
    style A fill:none,stroke:none

```

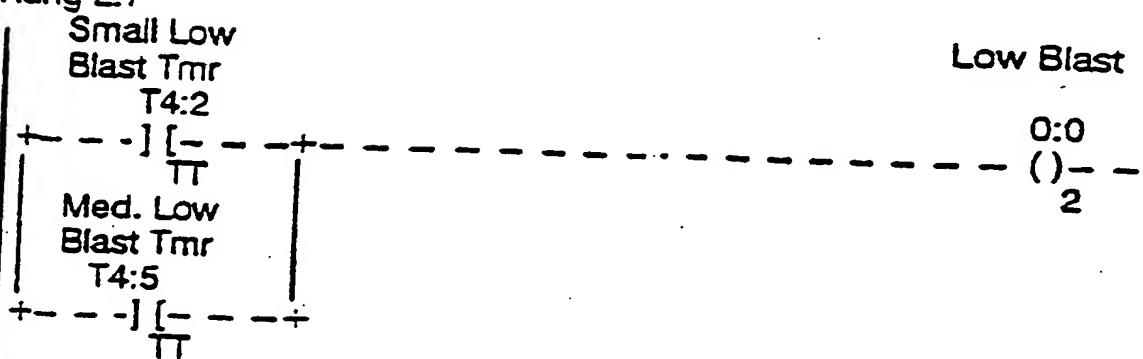
FIG. 12R

AIR ASSISTED COLLATOR PROGRAM LISTING

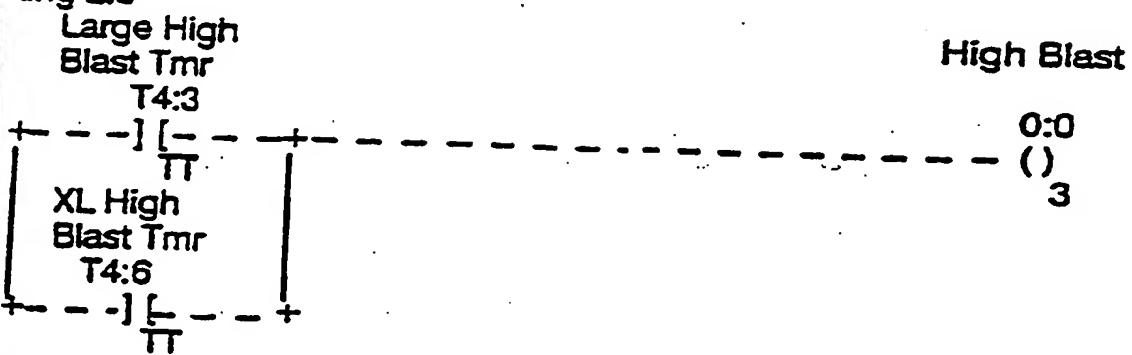
Rung 2:6



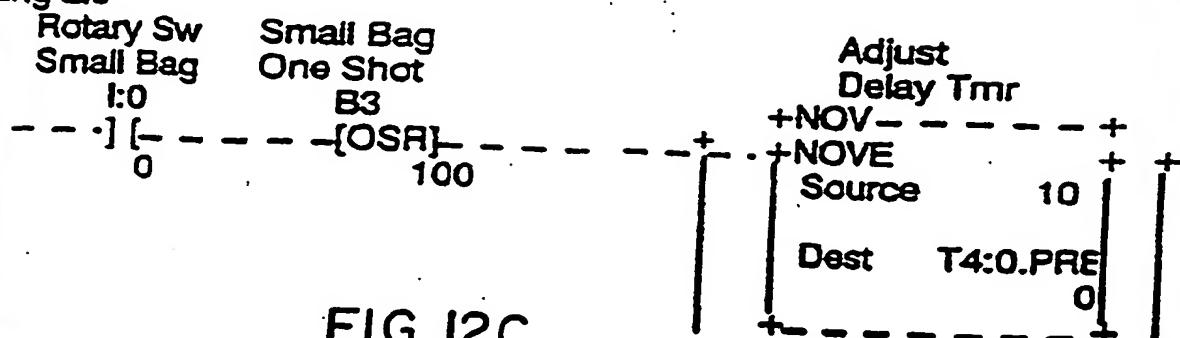
Rung 2:7



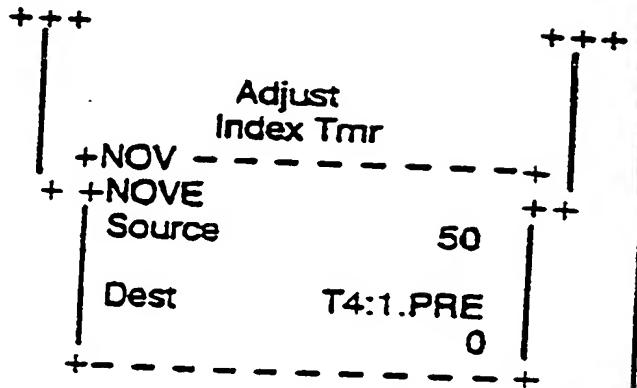
Rung 2:8



Rung 2:9

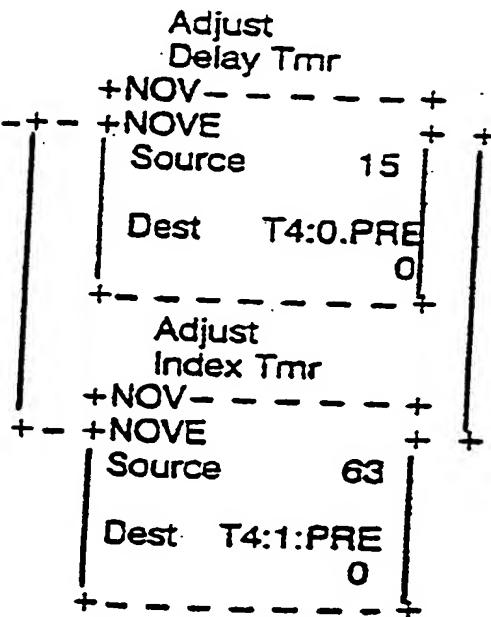


AIR ASSISTED COLLATOR PROGRAM LISTING



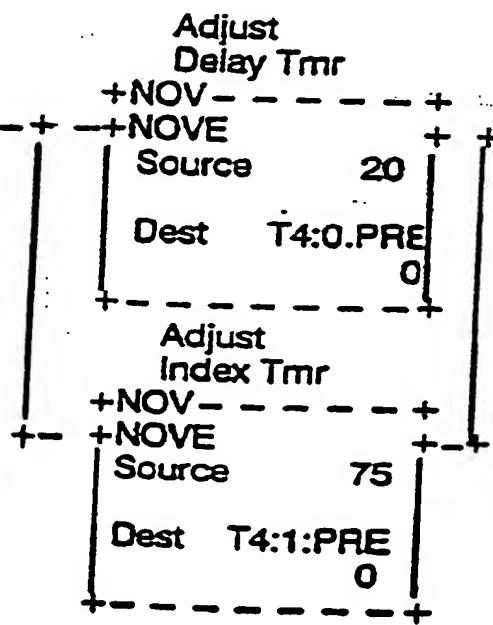
Rung 2:10

Rotary Sw	Med Bag
Med Bag	One Shot
I:0	B3
- - -] [- - - - [CSR]	101



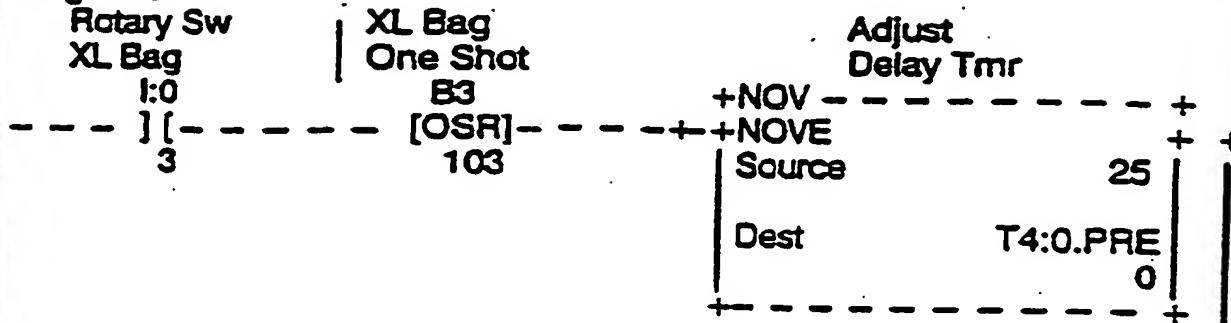
Rung 2:11

Rotary Sw	Large Bag
Large Bag	One Shot
I:0	B3
- - -] [- - - - [OSR]	102

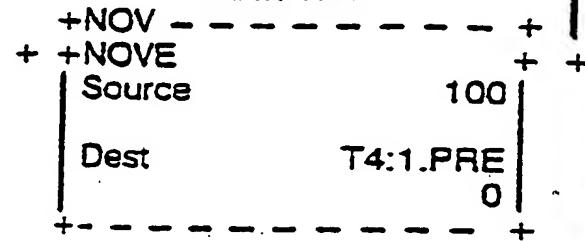


AIR ASSISTED COLLATOR PROGRAM LISTING

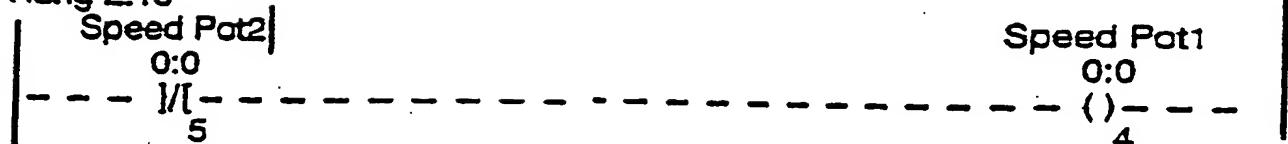
Rung 2:12



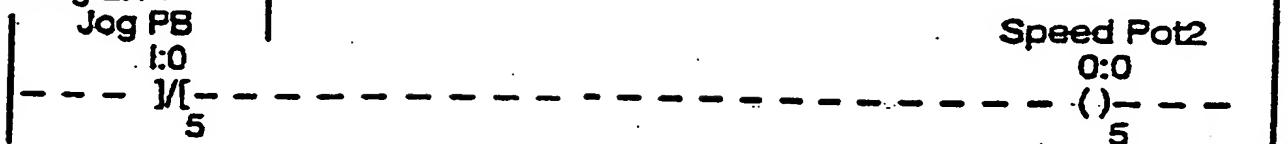
Adjust
Index Tmr



Rung 2:13



Rung 2:14



Rung 2:15

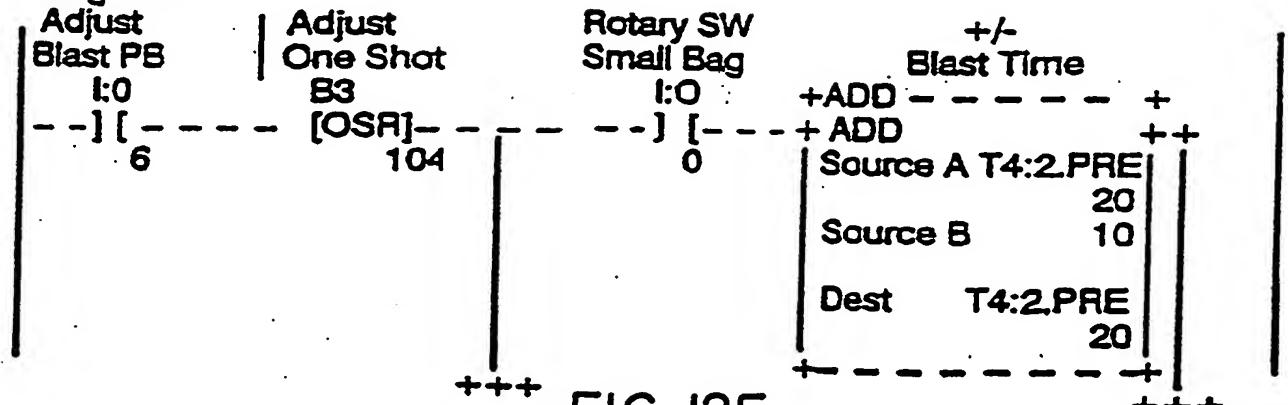
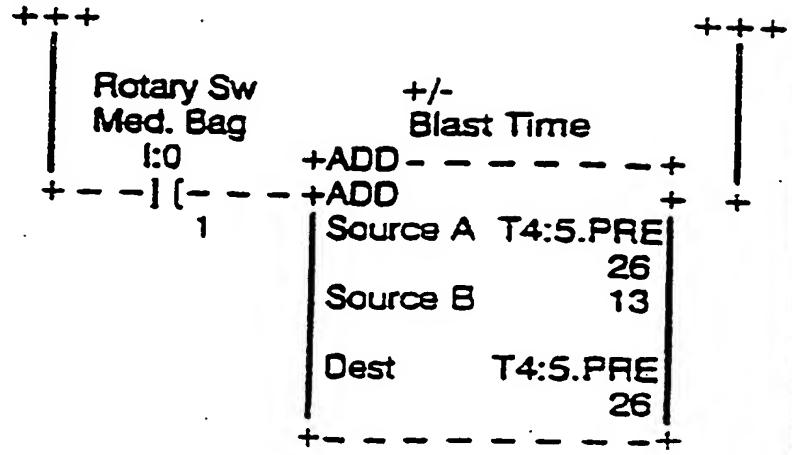
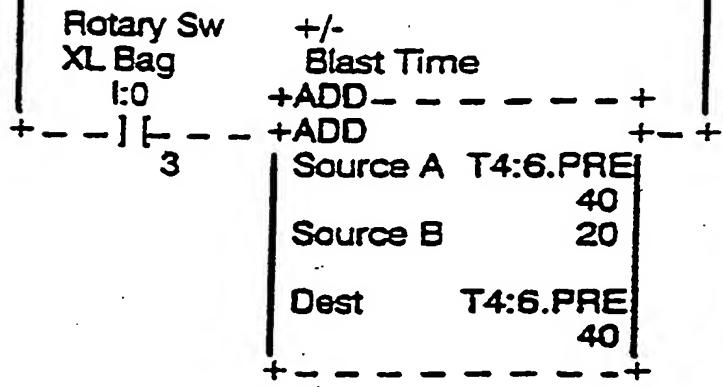
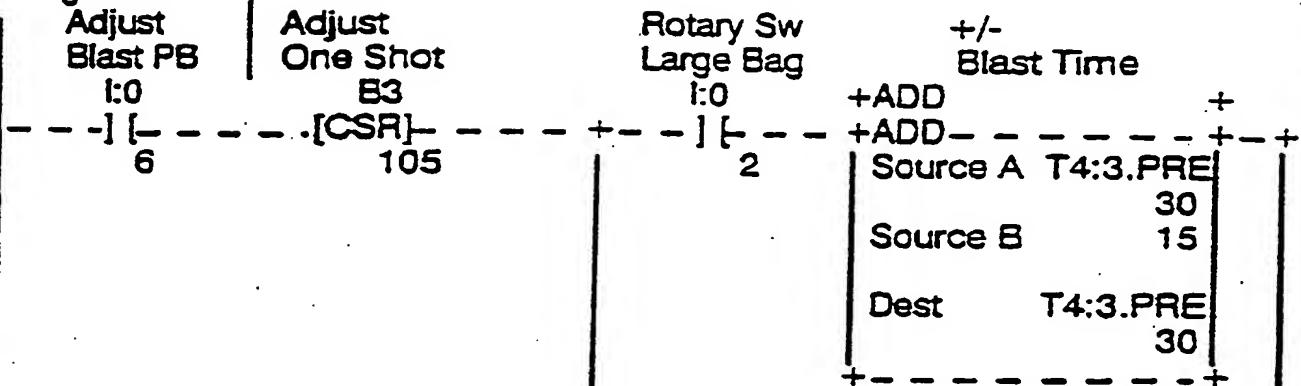


FIG. I2F

AIR ASSISTED COLLATOR PROGRAM LISTING



Rung 2:16



Rung 2:17

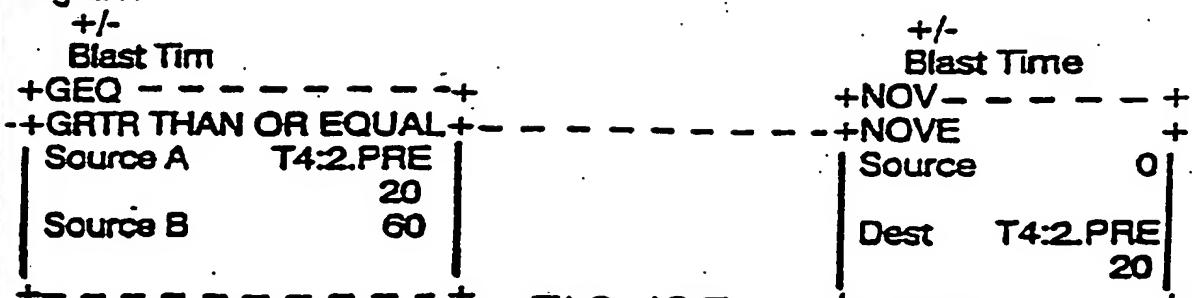
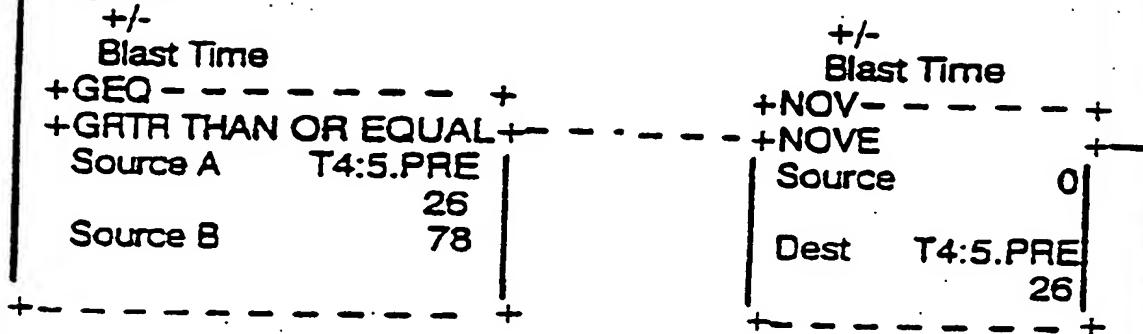


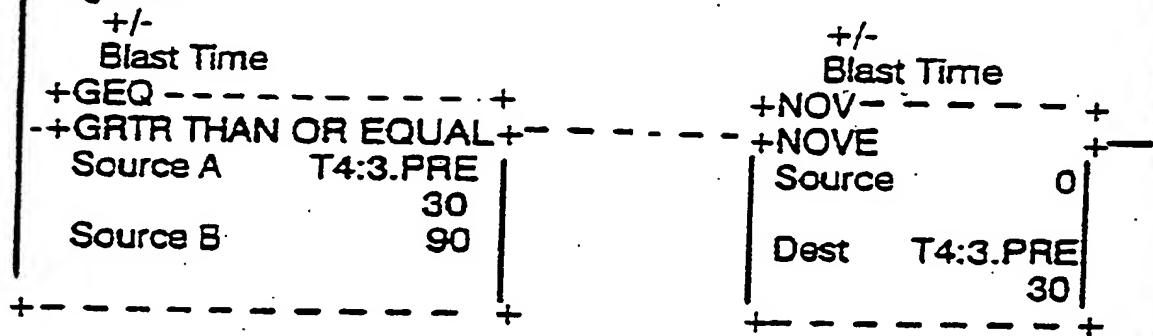
FIG. I2F

AIR ASSISTED COLLATOR PROGRAM LISTING

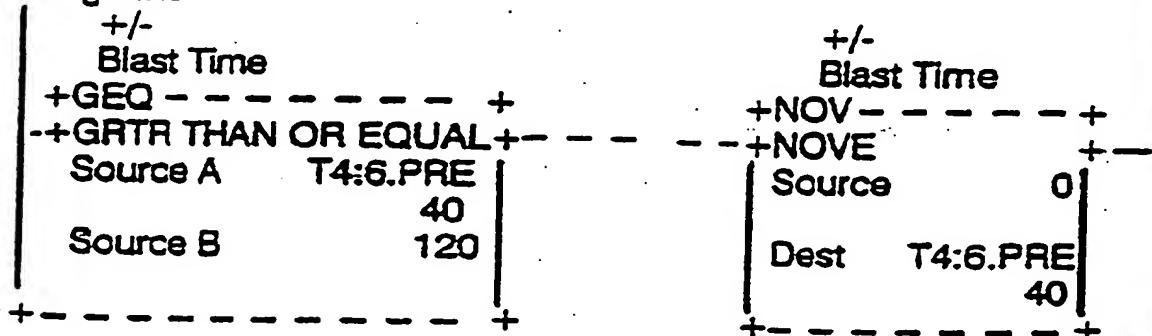
Rung 2:18



Rung 2:19



Rung 2:20



Rung 2:21

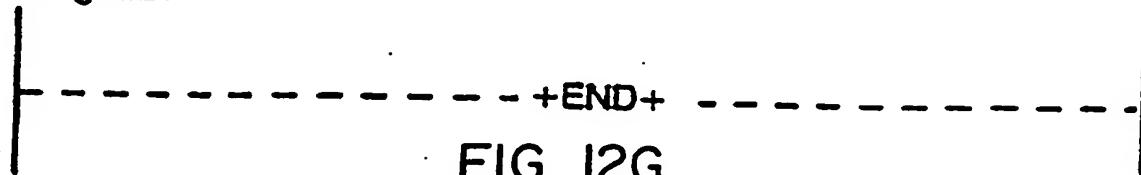


FIG. I2G

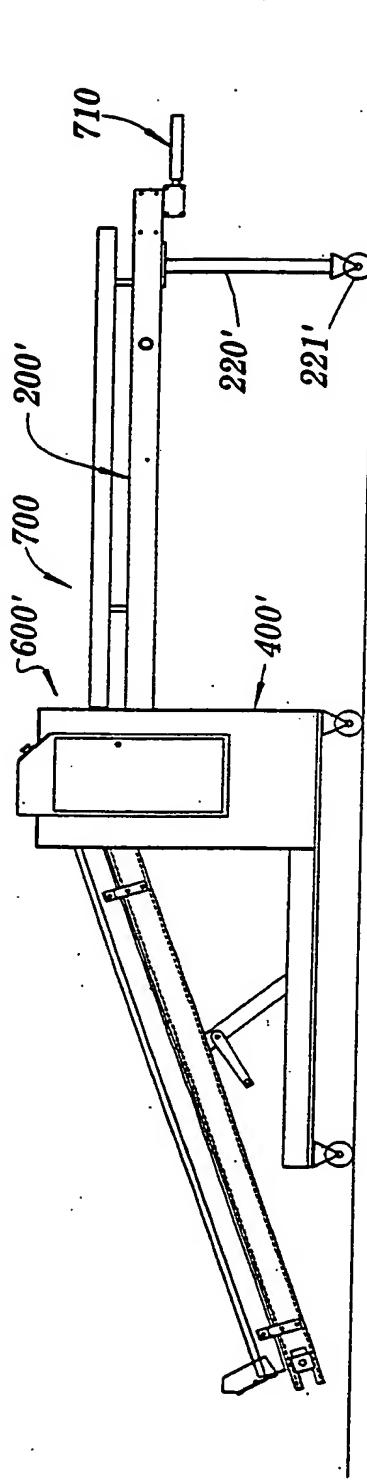


Fig. 13

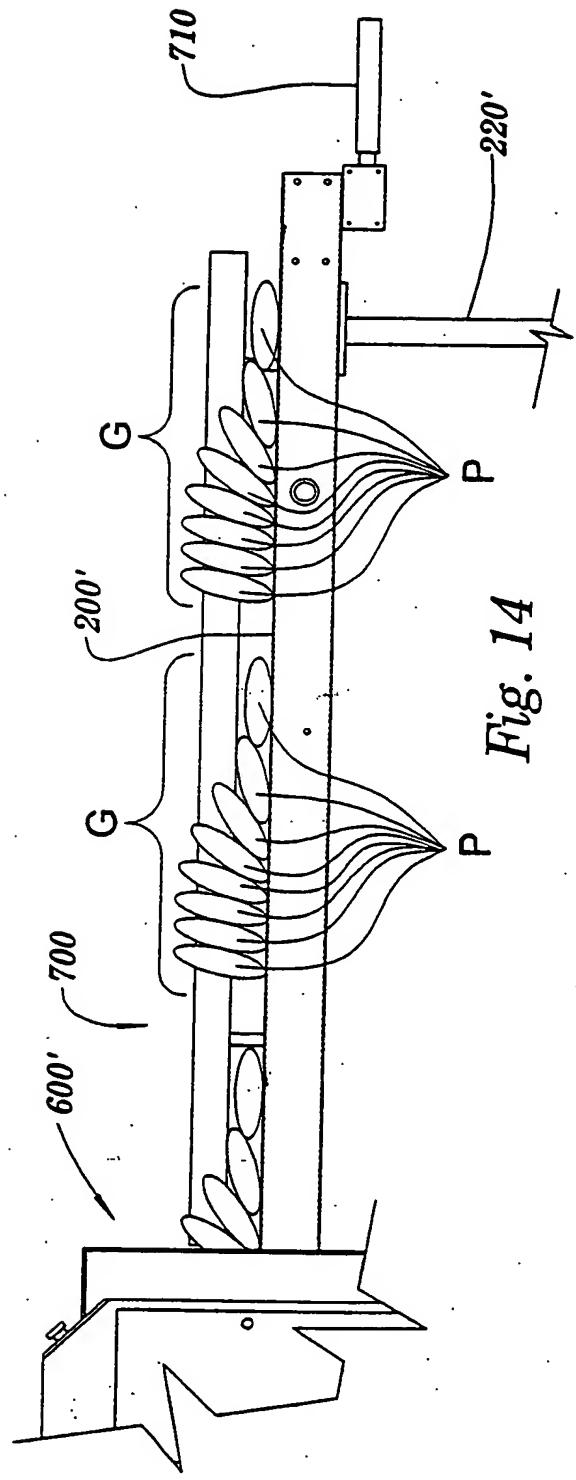


Fig. 14

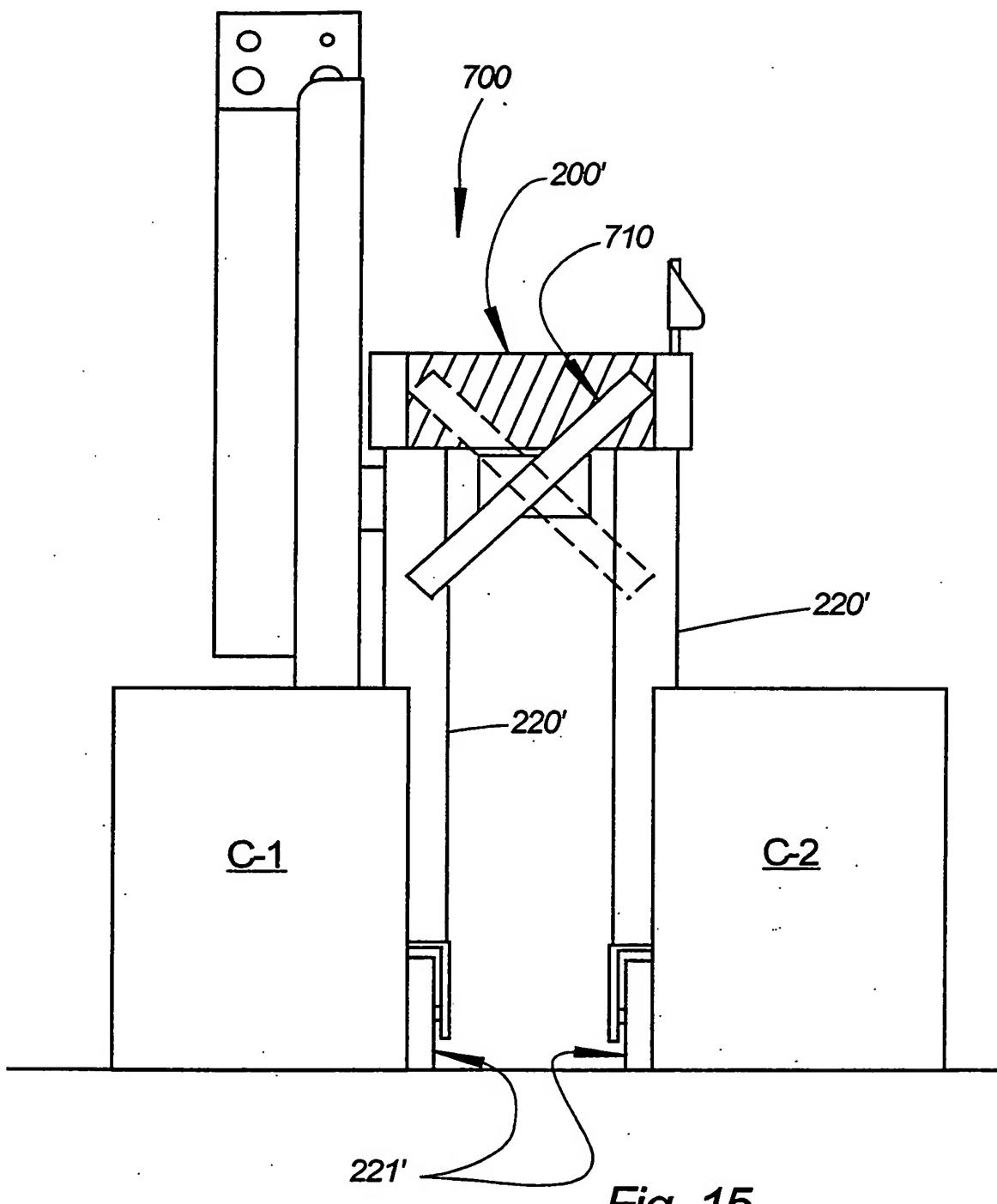
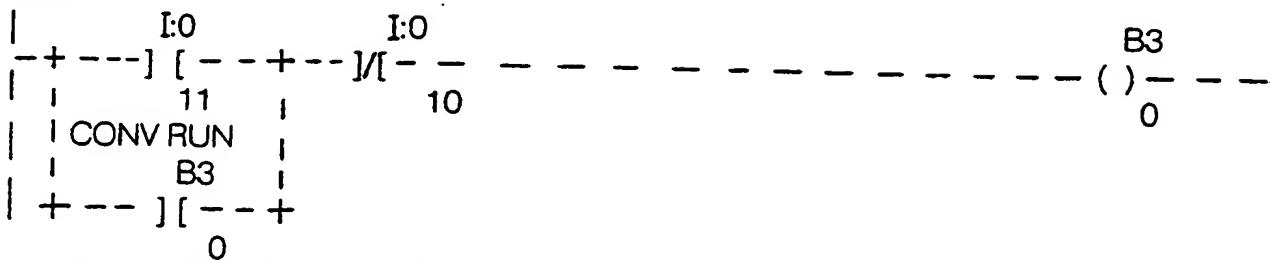


Fig. 15

RUNG 2:0 - START/STOP CONTROL.

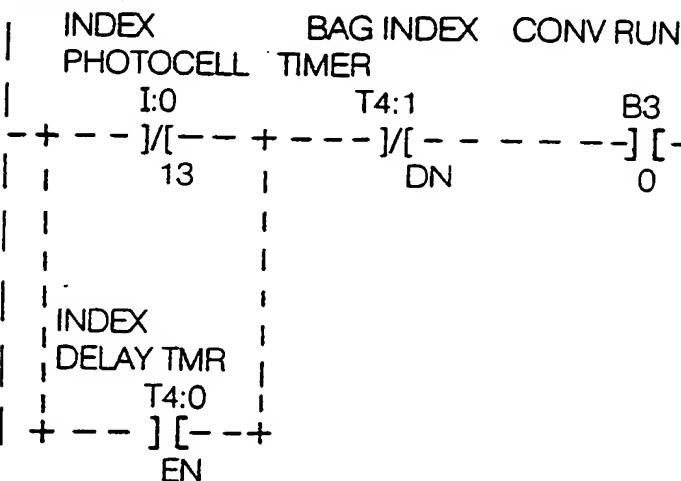
RUNG 2:0 START PB E-STOP
RUN

CONV

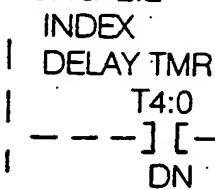


RUNG 2:1 AND 2:2 - INDEXING CONTROLS.

RUNG 2:1

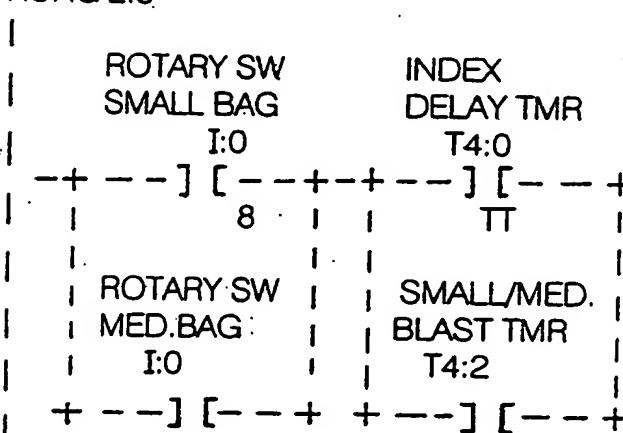


RUNG 2:2



RUNGS 2:3 THRU 2:5-AIR BLAST TIMER CONTROLS.

RUNG 2:3



INDEX
DELAY TMR

+TON - - - - +
+TIMER ON DELAY +- (EN)-|
| TIMER T4:0 | (DN)|
| TIME BASE 0.01 |
| PRESET 5 |
| ACCUM 0 |
+ - - - - +

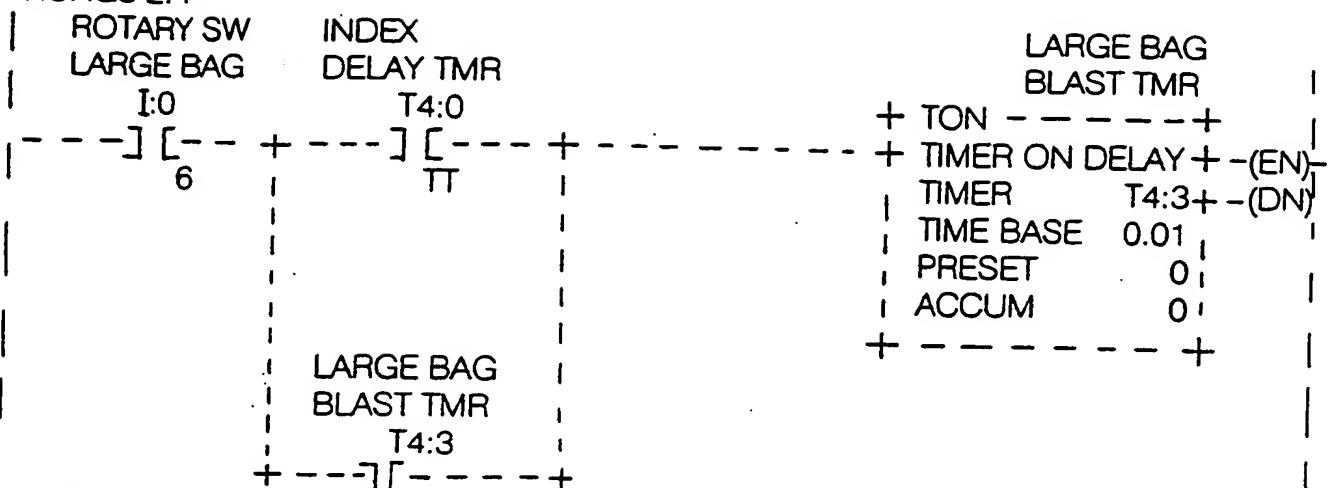
BAG INDEX
TIMER

+TON - - - - +
+TIMER ON DELAY +- (EN)-|
| TIMER T4:1 | +- (DN) |
| TIME BASE 0.01 |
| PRESET 25 |
| ACCUM 0 |
+ - - - - +

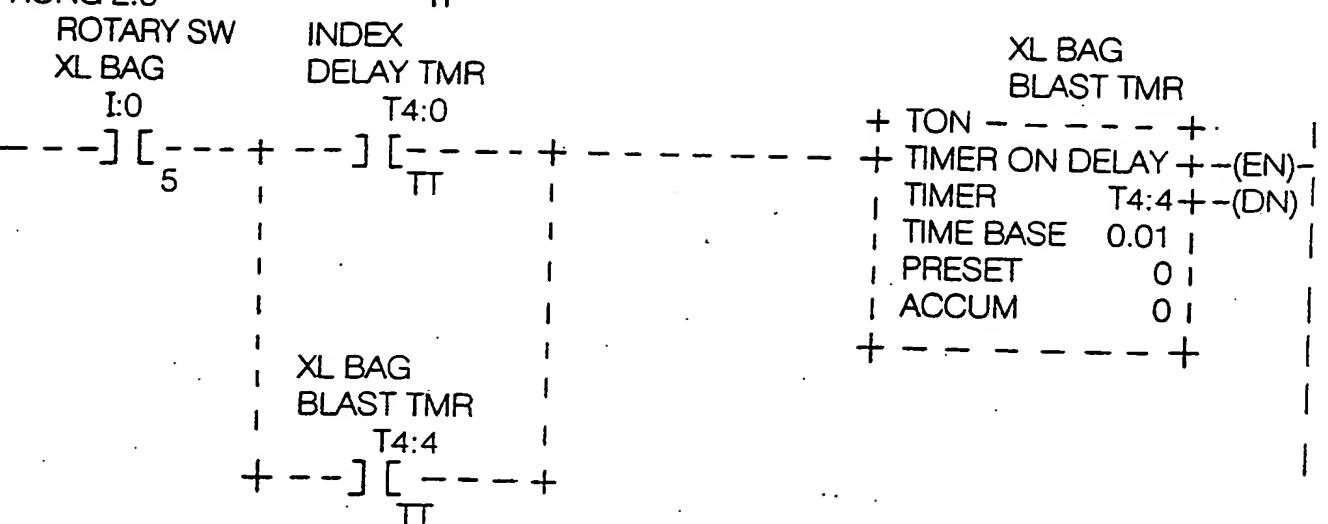
SMALL/MED.
BLAST TMR

+TON - - - - +
+TIMER ON DELAY +- (EN)-|
| TIMER T4:2 | +- (DN) |
| TIME BASE 0.01 |
| PRESET 20 |
| ACCUM 0 |
+ - - - - +

RUNGS 2:4



RUNG 2:5



RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.
RUNG 2:6

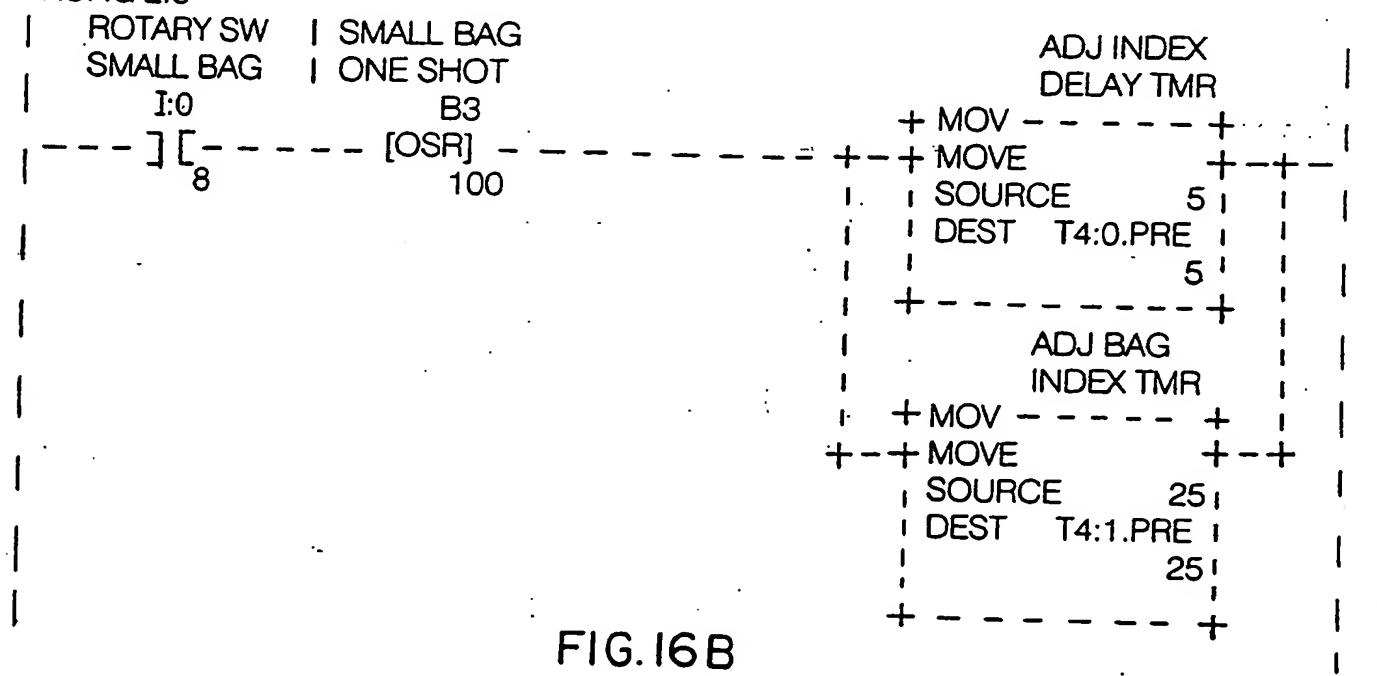
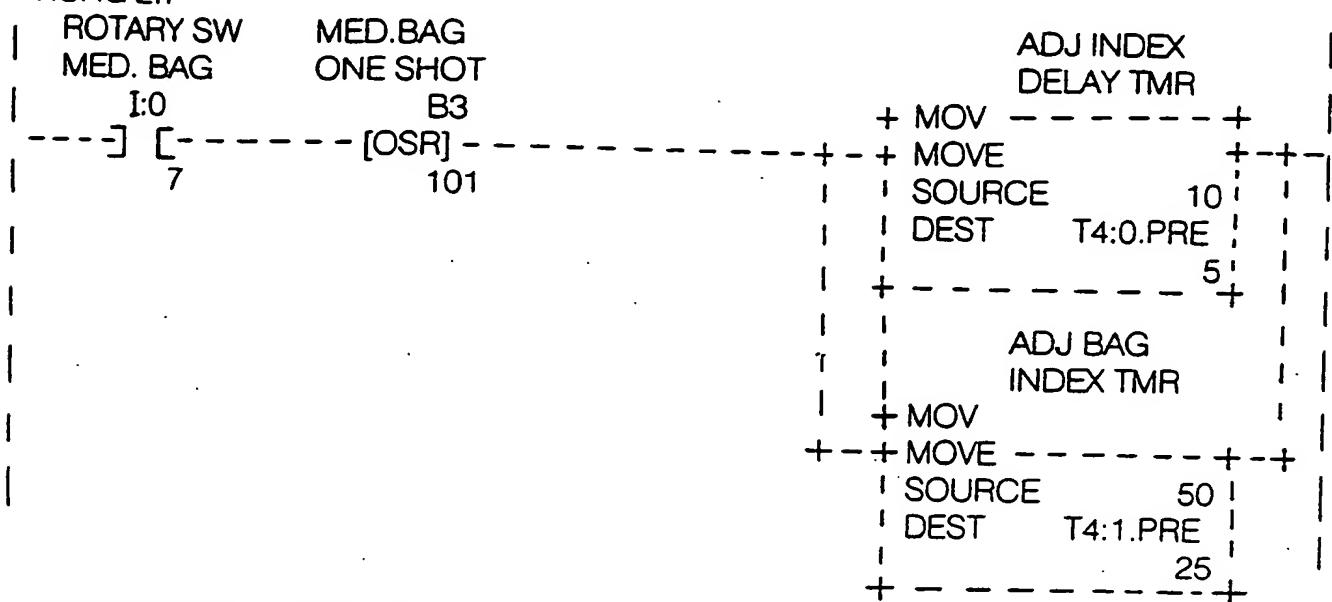


FIG. 16B

RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.
RUNG 2:7



RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.
RUNG 2:8

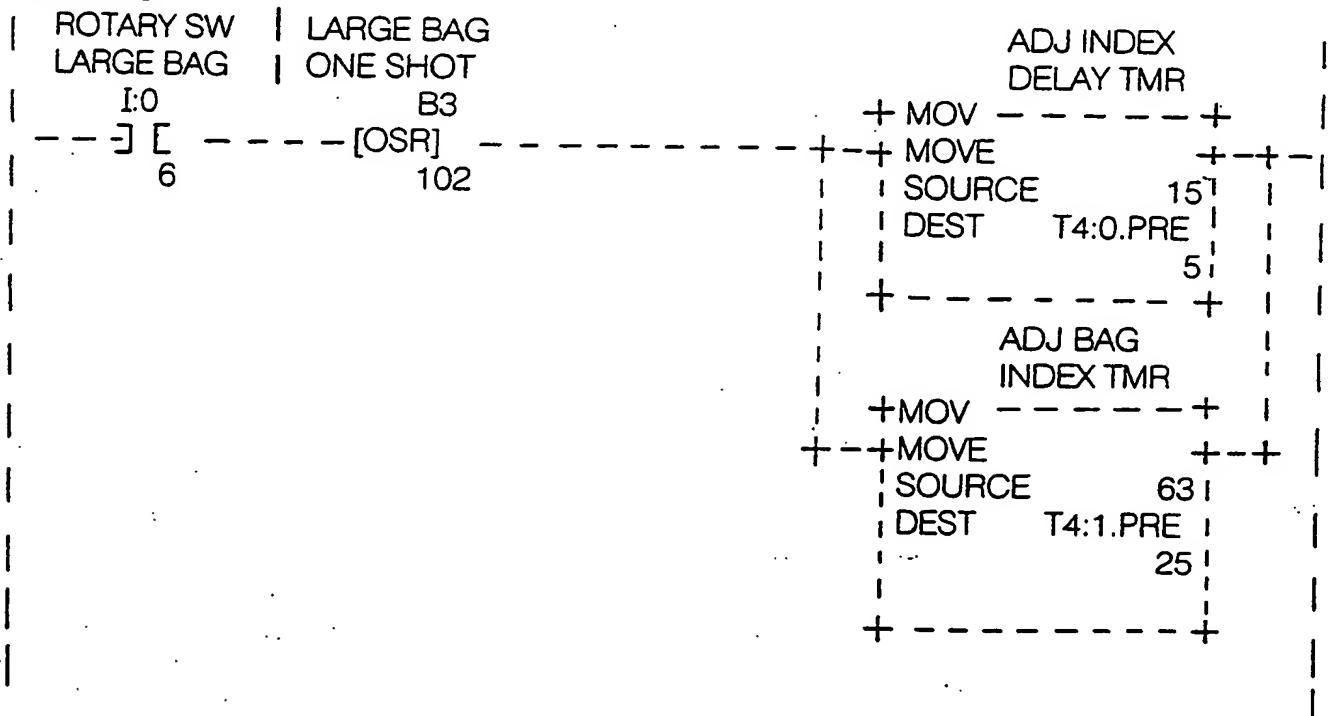
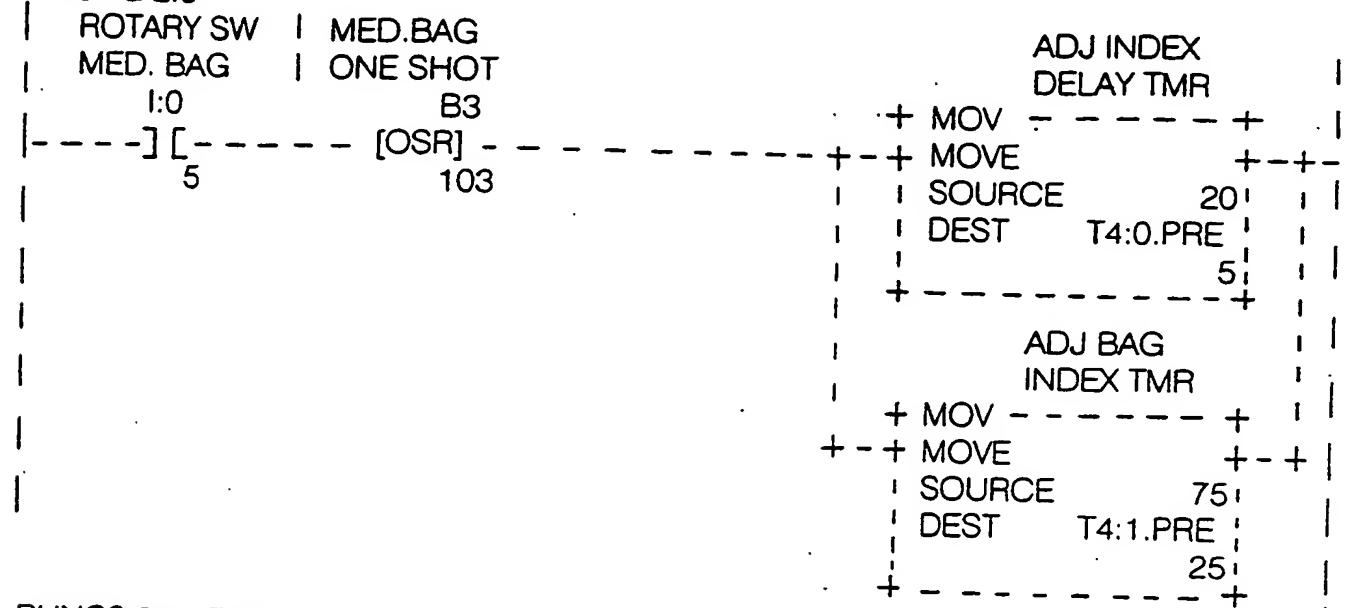
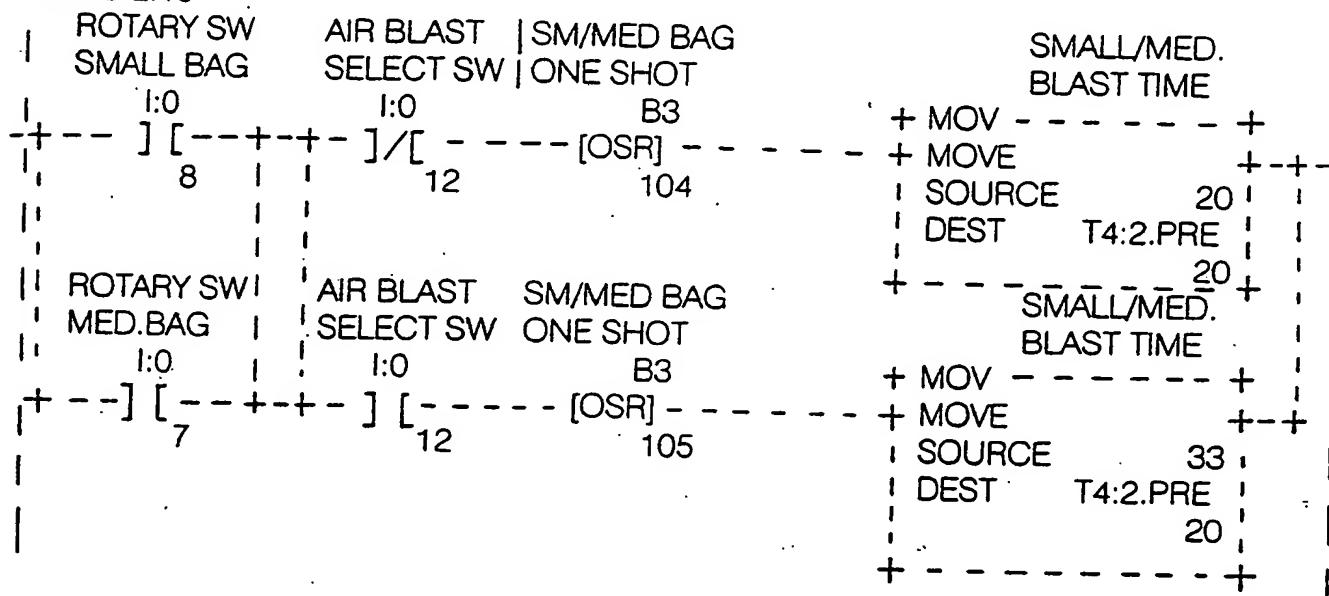


FIG. 16C

RUNGS 2:6 THRU 2:9-INDEX DELAY AND BAG INDEX TIMER ADJUSTMENT CONTROLS.
RUNG 2:9



RUNGS 2:10 THRU 2:12-LONG/SHORT AIR BLAST TIME CONTROLS.
RUNG 2:10



RUNGS 2:11

ROTARY SW	AIR BLAST	LARGE BAG	LARGE BAG
LARGE BAG	SELECT SW	ONE SHOT	BLAST TIME
I:0	I:0	B3	+ MOV ----- +
- - -] [- - - + - - -]/[- - - [OSR] - - - + MOVE	6	12	----- +
		106	SOURCE 33
			DEST T4:3.PRE
			0
			+ - - - - +
	AIR BLAST	LARGE BAG	LARGE BAG
	SELECT SW	ONE SHOT	BLAST TIME
	I:0	B3	+ MOV ----- +
+ - -] [- - - [OSR] - - - + MOVE	12	107	----- +
			SOURCE 50
			DEST T4:3.PRE
			0
			+ - - - - +

RUNG 2:12

ROTARY SW	AIR BLAST	XL BAG	XL BAG
XL BAG	SELECT SW	ONE SHOT	BLAST TIME
I:0	I:0	B3	+ MOV ----- +
[-----+--]	/[- - - [OSR]	12	+ MOVE
5		108	SOURCE 50
			DEST T4:4.PRE
			0
			+-----+
AIR BLAST	XL BAG	XL BAG	XL BAG
SELECT SW	ONE SHOT		BLAST TIME
I:0	B3	+ MOV ----- +	
+--]	/[- - - [OSR]	12	+ MOVE
		109	SOURCE 75
			DEST T4:4.PRE
			0
			+-----+

RUNGS 2:13 AND 2:14 - AIR BLAST SOLENOID CONTROLS

RUNG 2:13

RUNGS 2:14

LARGE BAG

BLAST TMR

T4:3

HIGH AIR
BLAST SOL.
O:0

2

TT

XL BAG

BLAST TMR

T4:4

+---] [---+

TT

RUNGS 2:15 THRU 2:22 - DC MOTOR SPEED CONTROLS.

RUNG 2:15

FULL/JOG BAG INDEX PULLED GAP
SPEED TIMER SPEED

INDEXING
SPEED

O:0

T4:1

O:0

O:0

- - -]/[- - -]

9

TT

10

()-----

8

RUNG 2:16

JOG PB'S

FULL/JOG
SPEED

O:0

I:0

- + - -]

9

- - - + - - -

()-----

ROTARY SW

CONTINUOUS

I:0

+ - -]

4

- - - +

9

RUNG 2:17

ROTARY SW INDEXING | FULL/JOG | GAP TIMER | PULLED GAP
SMALL BAG SPEED | SPEED | | SPEED

I:0

O:0

O:0

T4:5

O:0

- + - -]

8

- - + - -]

8

- - - + - - -

9

TT

()-----

10

ROTARY SW

MED. BAG

I:0

+ - -]

7

- - + - -

ROTARY SW

LARGE BAG

I:0

+ - -]

6

- - + - -

ROTARY SW

XL BAG

I:0

+ - -]

5

FIG. 16F

RUNGS 2:18

ROTARY SW	SMALL BAG	GAP TIMER
SMALL BAG	ONE SHOT	
I:0	B3	+ MOV - - - - +
- - -] [- - - - [OSR] - - - - - - - - -	8 110	+ MOVE + -
		SOURCE 50
		DEST T4:5.PRE
		50
		+ - - - - - +

RUNG 2:19

ROTARY SW	MED.BAG	GAP TIMER
MED.BAG	ONE SHOT	
I:0	B3	+ MOV - - - - +
- - -] [- - - - [OSR] - - - - - - - - -	7 111	+ MOVE + -
		SOURCE 63
		DEST T4:5.PRE
		50
		+ - - - - - +

RUNG 2:20

ROTARY SW	LARGE BAG	GAP TIMER
LARGE BAG	ONE SHOT	
I:0	B3	+ MOV - - - - +
- - -] [- - - - [OSR] - - - - - - - - -	6 112	+ MOVE + -
		SOURCE 75
		DEST T4:5.PRE
		50
		+ - - - - - +

RUNG 2:21

ROTARY SW.	XL BAG	GAP TIMER
XL BAG	ONE SHOT	
I:0	B3	+ MOV - - - - +
- - -] [- - - - [OSR] - - - - - - - - -	5 113	+ MOVE + -
		SOURCE 100
		DEST T4:5.PRE
		50
		+ - - - - - +

RUNG 2:22

COUNTER	C5:1	GAP TIMER
- + - -] [- - + - - - - - - - - -	DN	+ TON +
		+ TIMER ON DELAY +(EN) -
		TIMER T4:5+(DN)
		TIME BASE 0.01
		PRESET 50
		ACCUM 0
		+ - - - - - +
GAP TIMER	T4:5	
- - -] [- - +	TT	

FIG. 16G

RUNGS 2:23 THRU 2:28 - OPTIONAL LOOSE PACK CONTROLS.

RUNG 2:23

ROTARY SW CONTINUOUS	COUNTER	LOOSE PACK OSCILLATOR
I:0	C5:1	+ CTU - - - - +
- - -] [- - - - -] [- - - - - - - -	DN	+ COUNT UP +-(CU)-
4		COUNTER C5:0+-(DN)
		PRESET 2
		ACCUM 0
		+ - - - - - - - +

RUNG 2:24

SWITCHING BIT $B3$ 114	SWITCH DEL TIMER #1 $T4:6$ DN	SWITCH DEL TIMER #1 $+TON$ $+ \text{TIMER ON DELAY}$ $+ \text{TIMER}$ $T4:6 + - (DN)$ $TIME BASE$ 0.01 $PRESET$ 50 $ACCUM$ 0
		$+ - - - - - - - - +$
SWITCH DEL TIMER #1 $T4:6$ $+ - - -] [- - - +$ EN		

RUNG 2:25

BLING 2-26

ROUTINE 2.20
| SWITCH DEL | LOOSE PACK
| TIMER #1 | DIVERTER
| T4:6 O:0
| -----] [----- (L) -----
| DN 3

FIG. 16H

RUNGS 2:27

<p>LOOSE PACK OSCILLATOR</p> <p>+ EQU ----- +</p> <p>-+ + EQUAL</p> <p> SOURCE A C5:0.ACC</p> <p> 0</p> <p> SOURCE B</p> <p> 2</p> <p>+-----+</p> <p>SWITCH DEL TIMER #2 T4:7</p> <p>+---] [-----+ EN</p>	<p>SWITCH DEL TIMER #2</p> <p>T4:7</p> <p>-+ +]/[-----+ DN</p> <p>+-----+</p>	<p>LOOSE PACK OSCILLATOR</p> <p>+ MOV ----- +</p> <p>-+ + MOVE</p> <p> SOURCE 0</p> <p> DEST C5:0.ACC</p> <p> 0</p> <p>+-----+</p> <p>SWITCH DEL TIMER #2</p> <p>+ TON ----- +</p> <p>+---+ TIMER ON DELAY +- (EN) -+ TIMER T4:7 -+ (DN)</p> <p> TIME BASE 0.01 </p> <p> PRESET 50 </p> <p> ACCUM 0 </p> <p>+-----+</p>
---	--	--

RUNG 2:28

SWITCH DEL | LOOSE PACK
TIMER #2 | DIVERTER
T4:7 O:0
---] [----- (U) -----
DN 3

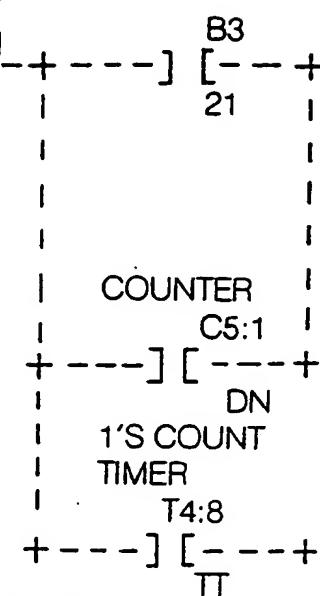
RUNGS 2:29 THRU 2:32-STROBE CONTROLS. THE OUTPUTS WILL STROBE ONCE WHENEVER THE START BUTTON IS PRESSED, OR WHEN THE COUNTER REACHES IT'S COUNT. THIS WILL LOAD THE VALUE ONTHE THUMBWHEEL SWITCHES INTO MEMORY.
RUNG 2:29

RUNG 2:29

FIG. 16I

RUNG 2:30

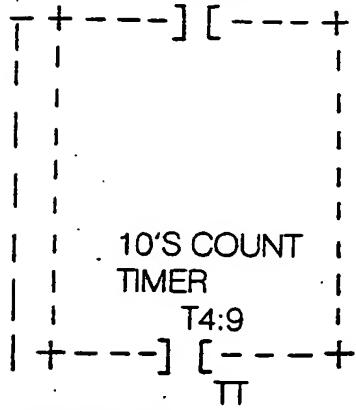
START



RUNG 2:31

1'S COUNT
TIMER

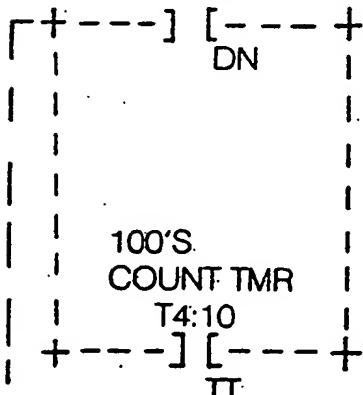
T4:8



RUNG 2:32

10'S COUNT
TIMER

T4:9

1'S COUNT
TIMER

+TON - - - - +

++TIMER ON DELAY+- (EN)-+-

++TIMER T4:8+- (DN) |

| TIME BASE 0.01 |

| PRESET 10 |

| ACCUM 0 |

+ - - - - - +

1'S COUNT

O:0

+ - - () - - - - - +

4

10'S COUNT
TIMER

+TON - - - - +

++TIMER ON DELAY+- (EN)-+-

| TIMER T4:9+- (DN) |

| TIME BASE 0.01 |

| PRESET 10 |

| ACCUM 0 |

+ - - - - - +

10'S COUNT

O:0

+ - - () - - - - - +

5

100'S
COUNT TMR

+TON - - - - +

++TIMER ON DELAY+- (EN)-+-

| TIMER T4:10+- (DN) |

| TIME BASE 0.01 |

| PRESET 10 |

| ACCUM 0 |

+ - - - - - +

100'S
COUNT

O:0

+ - - () - - - - - +

6

FIG. 16J

RUNGS 2:33 THRU 2:42-NUMBER CONTROL FOR ALL THUMBWHEEL SWITCHES.

RUNG 2:33

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	ZERO
I:0	I:0	I:0	I:0	
[---]/[-----]/[-----]/[-----]/[-----] ()-----				B3
0	1	2	3	10

RUNG 2:34

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	ONE
I:0	I:0	I:0	I:0	
[---]/[-----]/[-----]/[-----]/[-----] ()-----				B3
0	1	2	3	11

RUNG 2:35

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	TWO
I:0	I:0	I:0	I:0	
[---]/[-----]/[-----]/[-----]/[-----] ()-----				B3
0	1	2	3	12

RUNG 2:36

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	THREE
I:0	I:0	I:0	I:0	
[---]/[-----]/[-----]/[-----]/[-----] ()-----				B3
0	1	2	3	13

RUNG 2:37

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	FOUR
I:0	I:0	I:0	I:0	
[---]/[-----]/[-----]/[-----]/[-----] ()-----				B3
0	1	2	3	14

RUNG 2:38

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	FIVE
I:0	I:0	I:0	I:0	
[---]/[-----]/[-----]/[-----]/[-----] ()-----				B3
0	1	2	3	15

RUNG 2:39

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	SIX
I:0	I:0	I:0	I:0	
[---]/[-----]/[-----]/[-----]/[-----] ()-----				B3
0	1	2	3	16

RUNG 2:40

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	SEVEN
I:0	I:0	I:0	I:0	
[---]/[-----]/[-----]/[-----]/[-----] ()-----				B3
0	1	2	3	17

RUNG 2:41

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	EIGHT
I:0	I:0	I:0	I:0	
[---]/[-----]/[-----]/[-----]/[-----] ()-----				B3
0	1	2	3	18

RUNGS 2:42

1'S STROBE	2'S STROBE	4'S STROBE	8'S STROBE	NINE
I:0	I:0	I:0	I:0	B3
- - -]	- - -]	/ - - -]	/ - - -]	- - - () - - -
0	1	2	3	19

RUNGS 2:43 THRU 2:47-EVALUATE THUMBWHEEL SETTINGS AND LOAD VALUE INTO N7:0.

RUNG 2:43

1'S COUNT	ZERO	I'S PLACE
O:0	B3	+ MOV - - - +
- - -]	[- - - + - -]	+ MOVE
4	[- - - + - -]	SOURCE 0
		DEST N7:1
		3
		+ - - - - +
ONE		1'S PLACE
	B3	+ MOV - - - +
+ - - -]	[- - - + - -]	+ MOVE
	[- - - + - -]	SOURCE 1
		DEST N7:1
		3
		+ - - - - +
TWO		1'S PLACE
	B3	+ MOV - - - +
+ - - -]	[- - - + - -]	+ MOVE
	[- - - + - -]	SOURCE 2
		DEST N7:1
		3
		+ - - - - +
THREE		1'S PLACE
	B3	+ MOV - - - +
+ - - -]	[- - - + - -]	+ MOVE
	[- - - + - -]	SOURCE 3
		DEST N7:1
		3
		+ - - - - +
FOUR		1'S PLACE
	B3	+ MOV - - - +
+ - - -]	[- - - + - -]	+ MOVE
	[- - - + - -]	SOURCE 4
		DEST N7:1
		3
		+ - - - - +
FIVE		1'S PLACE
	B3	+ MOV - - - +
+ - - -]	[- - - + - -]	+ MOVE
	[- - - + - -]	SOURCE 5
		DEST N7:1
		3
		+ - - - - +

+ + +

+ + +

FIG. 16L

+---+
 | 1'S PLACE
 | B3 + MOV -----
 | 16 | MOVE
 | | SOURCE 6
 | | DEST N7:1
 | | 3
 | +-----+
 | SEVEN 1'S PLACE
 | B3 + MOV -----
 | 17 | MOVE
 | | SOURCE 7
 | | DEST N7:1
 | | 3
 | +-----+
 | EIGHT 1'S PLACE
 | B3 + MOV -----
 | 18 | MOVE
 | | SOURCE 8
 | | DEST N7:1
 | | 3
 | +-----+
 | NINE 1'S PLACE
 | B3 + MOV -----
 | 19 | MOVE
 | | SOURCE 9
 | | DEST N7:1
 | | 3
 | +-----+

RUNG 2:44

10'S COUNT ZERO 10'S PLACE
 | O:0 B3 + MOV -----
 | +---] [---+---] [--+
 | 5 10 | MOVE
 | | SOURCE 0
 | | DEST N7:2
 | | 0
 | +-----+
 | ONE 10'S PLACE
 | B3 + MOV -----
 | +---] [---+ MOVE
 | 11 | SOURCE 1
 | | DEST N7:2
 | | 0
 | +-----+
 | +---+

FIG. 16M

+ + + + + + + +
 | TWO |
 | B3 + MOV - - - - - + |
 +---+] [---+ MOVE |
 | 12 | SOURCE 2 |
 | | DEST N7:2 |
 | | 0 |
 | + - - - - - + |
 | THREE |
 | B3 + MOV - - - - - + |
 +---+] [---+ MOVE |
 | 13 | SOURCE 3 |
 | | DEST N7:2 |
 | | 0 |
 | + - - - - - + |
 | FOUR |
 | B3 + MOV - - - - - + |
 +---+] [---+ MOVE |
 | 14 | SOURCE 4 |
 | | DEST N7:2 |
 | | 0 |
 | + - - - - - + |
 | FIVE |
 | B3 + MOV - - - - - + |
 +---+] [---+ MOVE |
 | 15 | SOURCE 5 |
 | | DEST N7:2 |
 | | 0 |
 | + - - - - - + |
 | SIX |
 | B3 + MOV - - - - - + |
 +---+] [---+ MOVE |
 | 16 | SOURCE 6 |
 | | DEST N7:2 |
 | | 0 |
 | + - - - - - + |
 | SEVEN |
 | B3 + MOV - - - - - + |
 +---+] [---+ MOVE |
 | 17 | SOURCE 7 |
 | | DEST N7:2 |
 | | 0 |
 | + - - - - - + |

FIG. 16N

```

+ + + + +
|           EIGHT          10'S PLACE
|           B3  +MOV -----+
|           +-] [--+MOVE
|           18  |SOURCE      8
|           |DEST        N7:2
|           |
|           0
|           +-----+
|           NINE          10'S PLACE
|           B3  +MOV -----+
|           +-] [--+MOVE
|           19  |SOURCE      9
|           |DEST        N7:2
|           |
|           0
|           +-----+
|           MULTIPLY
|           BY 10
|           +MUL -----+
|           +MULTIPLY
|           | SOURCE A      10
|           | SOURCE B      N7:2
|           |
|           0
|           DEST         N7:3
|           0
|           +-----+

```

RUNG 2:45

100'S COUNT O:0	ZERO B3 -- - -] [- + - + -] [-- + MOV - - - - + 6 10 SOURCE 0 DEST N7:4 0 + - - - - - - + ONE 100'S PLACE B3 + MOV - - - - + + - -] [-- + MOVE + + + 11 SOURCE 1 DEST N7:4 0 + - - - - - - +
-----------------------	---

+++++ + + + + +

FIG. 160

+ + + + +		+ + +		+ + +
	TWO		100'S PLACE	
		B3 + MOV - - - - - +		
		+ ---] [- + MOVE		
		12 SOURCE	2	
		DEST	N7:4	
			0	
		+ - - - - - +		
	THREE		100'S PLACE	
		B3 + MOV - - - - - +		
		+ ---] [- + MOVE		
		13 SOURCE	3	
		DEST	N7:4	
			0	
		+ - - - - - +		
	FOUR		100'S PLACE	
		B3 + MOV - - - - - +		
		+ ---] [- + MOVE		
		14 SOURCE	4	
		DEST	N7:4	
			0	
		+ - - - - - +		
	FIVE		100'S PLACE	
		B3 + MOV - - - - - +		
		+ ---] [- + MOVE		
		15 SOURCE	5	
		DEST	N7:4	
			0	
		+ - - - - - +		
	SIX		100'S PLACE	
		B3 + MOV - - - - - +		
		+ ---] [- + MOVE		
		16 SOURCE	6	
		DEST	N7:4	
			0	
		+ - - - - - +		
	SEVEN		100'S PLACE	
		B3 + MOV - - - - - +		
		+ ---] [- + MOVE		
		17 SOURCE	7	
		DEST	N7:4	
			0	
		+ - - - - - +		

+++

FIG 16D

+++

FIG. 16Q

RUNG 2:47

| 100'S
| COUNT TMR
| T4:10

| -----] [----- DN

ADD TOTAL
TO 100'S

+ ADD ----- +

+ ADD ----- +

| SOURCE A N7:6 |

| 3 |

| SOURCE B N7:4 |

| 0 |

| DEST N7:0 |

| 3 |

+-----+

+ MOV ----- +

+-----+

+ ADD MOVE ----- +

| SOURCE N7:0 |

| DEST C5:1.PRE |

| 3 |

+-----+

COUNT SET AT ZERO

B3

RUNGS 2:48 THRU 2:50 COUNTER CONTROLS.
THE COUNTER IS RESET EVERY TIME IT
REACHES IT'S COUNT, AND RELOADS THE
THUMBWHEEL VALUE. THIS HAPPENS ALSO
WHEN THE START BUTTON IS PRESSED.

RUNG 2:48

| ADD TOTAL
| TO 100'S

+ EQ ----- +

-+ EQUAL +

| SOURCE A N7:0 |

| 3 |

| SOURCE B 0 |

+-----+ +

RUNG 2:49

COUNTER

| C5:1

-+---] [-+----- (RES) -----

| DN |

| START PB |

| I:0 |

| +---] [-+ +

| 11 |

COUNTER

C5:1

(RES) -----

RUNG 2:50

INDEX ROTARY SW COUNT SET CONV RUN COUNTER COUNTER
PHOTOCELL CONTINUOUS AT ZERO ONE SHOT

| I:0 I:0 B3 B3 B3 + CTU ----- +
| +---] / [- - -] / [- - + - -] / [- -] [- - [OSR] - + COUNT UP +-(CU)-
| 13 4 1 0 116 | COUNTER C5:1+-(DN)

| PRESET 3 |

| ACCUM 0 |

+-----+ +

| LOOSE PACK|ROTARY SW |

| PHOTOCELL|CONTINUOUS |

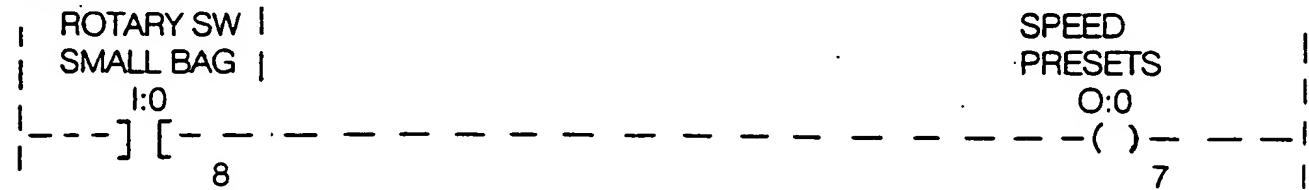
| I:0 I:0 |

+---] / [- - -] [- - +

| 14 4 |

RUNG 2:51-CONTROLS THE SELECTION OF VFD SPEED PRESETS. THE VFD WILL RUN AT SPEED PRESET #1 WHEN OUTPUT 7 IS LOW. SPEED PRESET #2 IS FOR SMALL BAGS. IF CONTINUOUS BAGS IS SELECTED, THE VFD WILL RUN AT A THIRD PRESET SPEED.

RUNG 2:51



RUNG 2:52

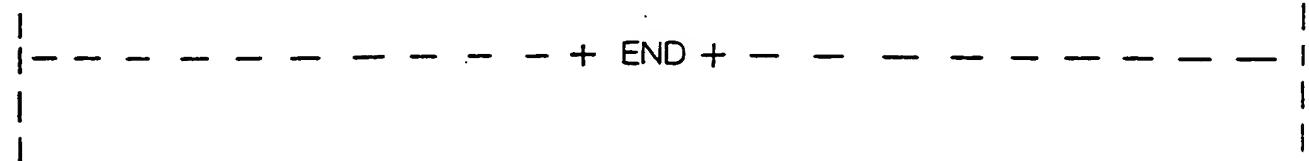


FIG.16S

120VAC, 1 Ph, 60 Hz
25 AMP POWER CORD

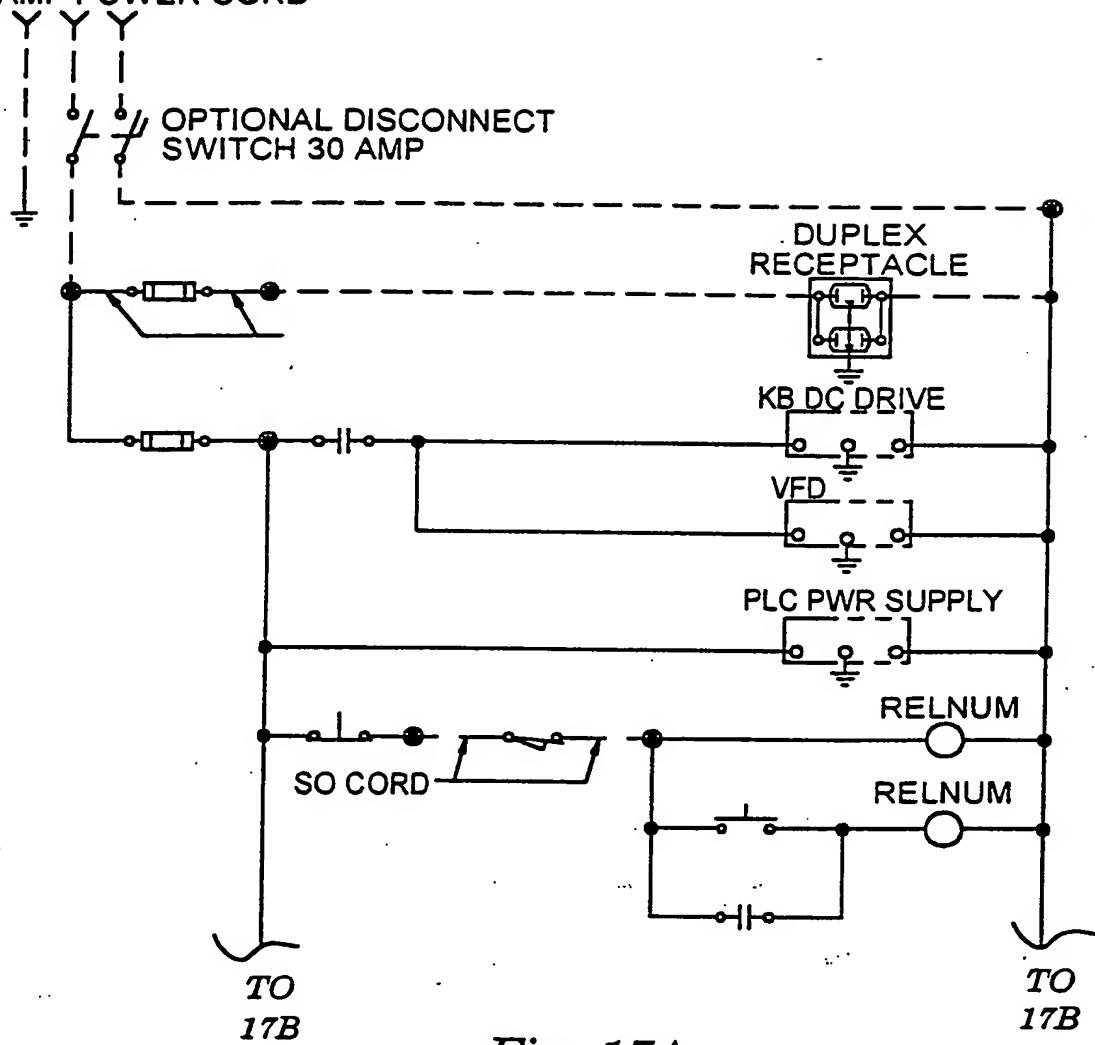


Fig. 17A

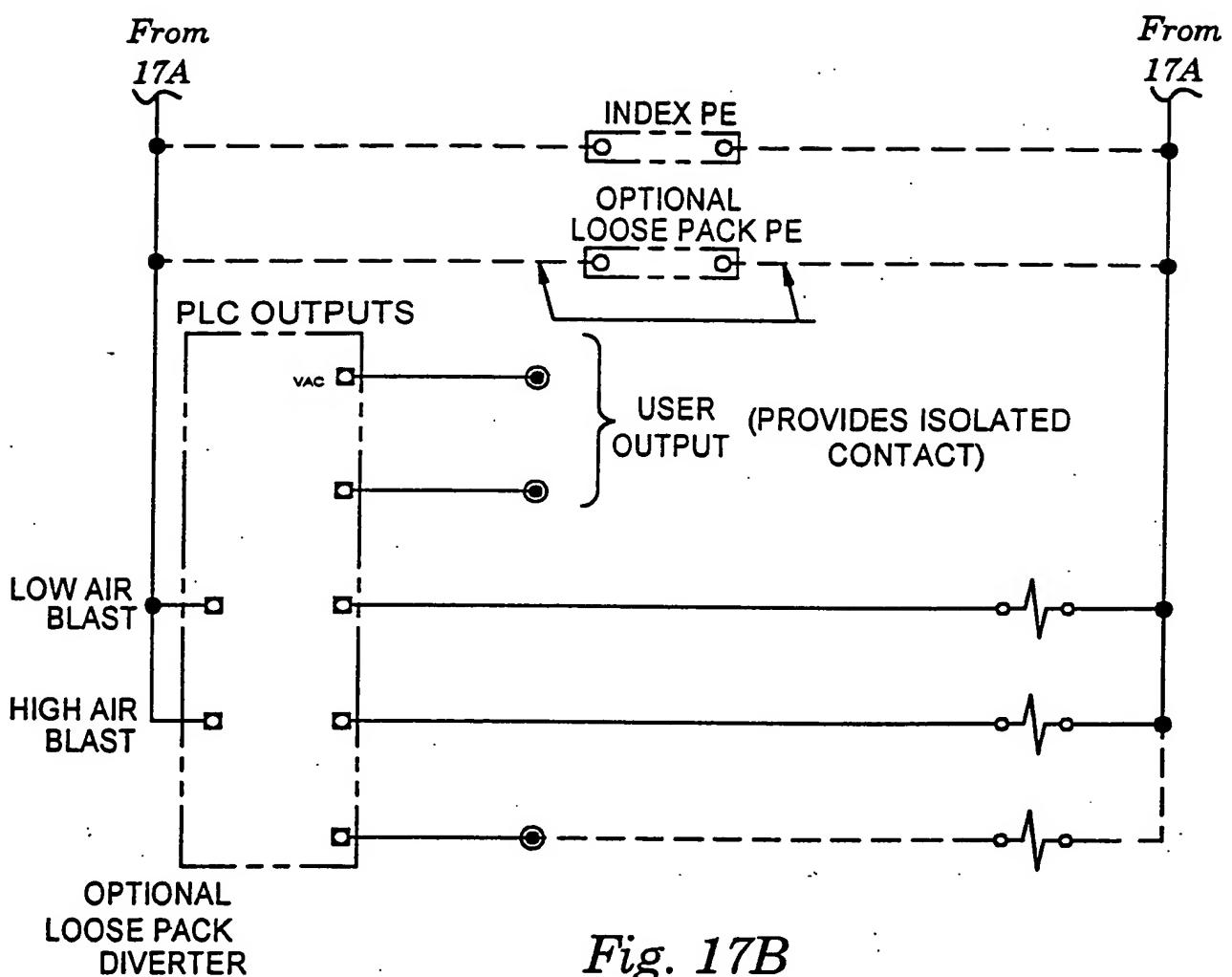
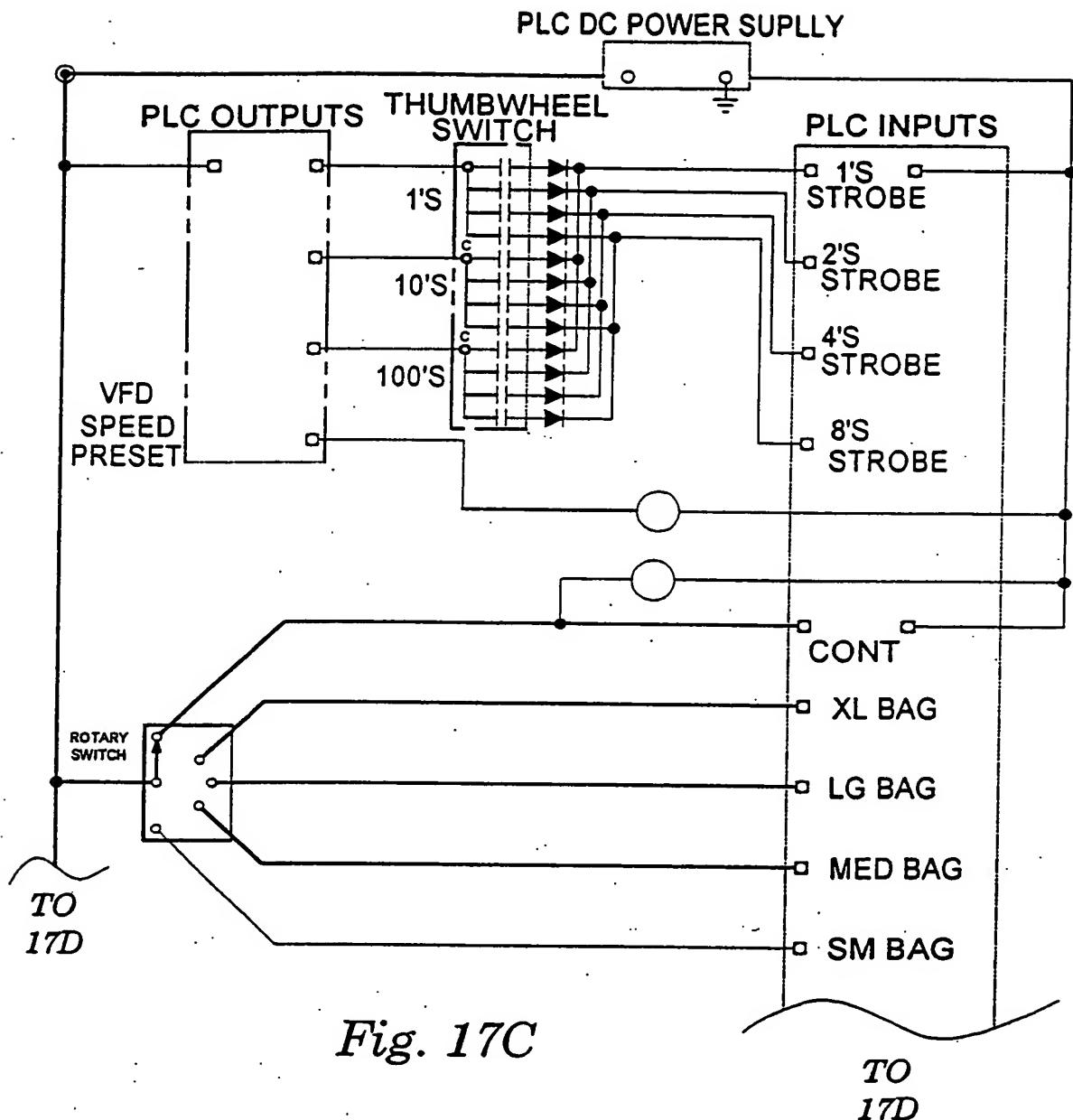


Fig. 17B



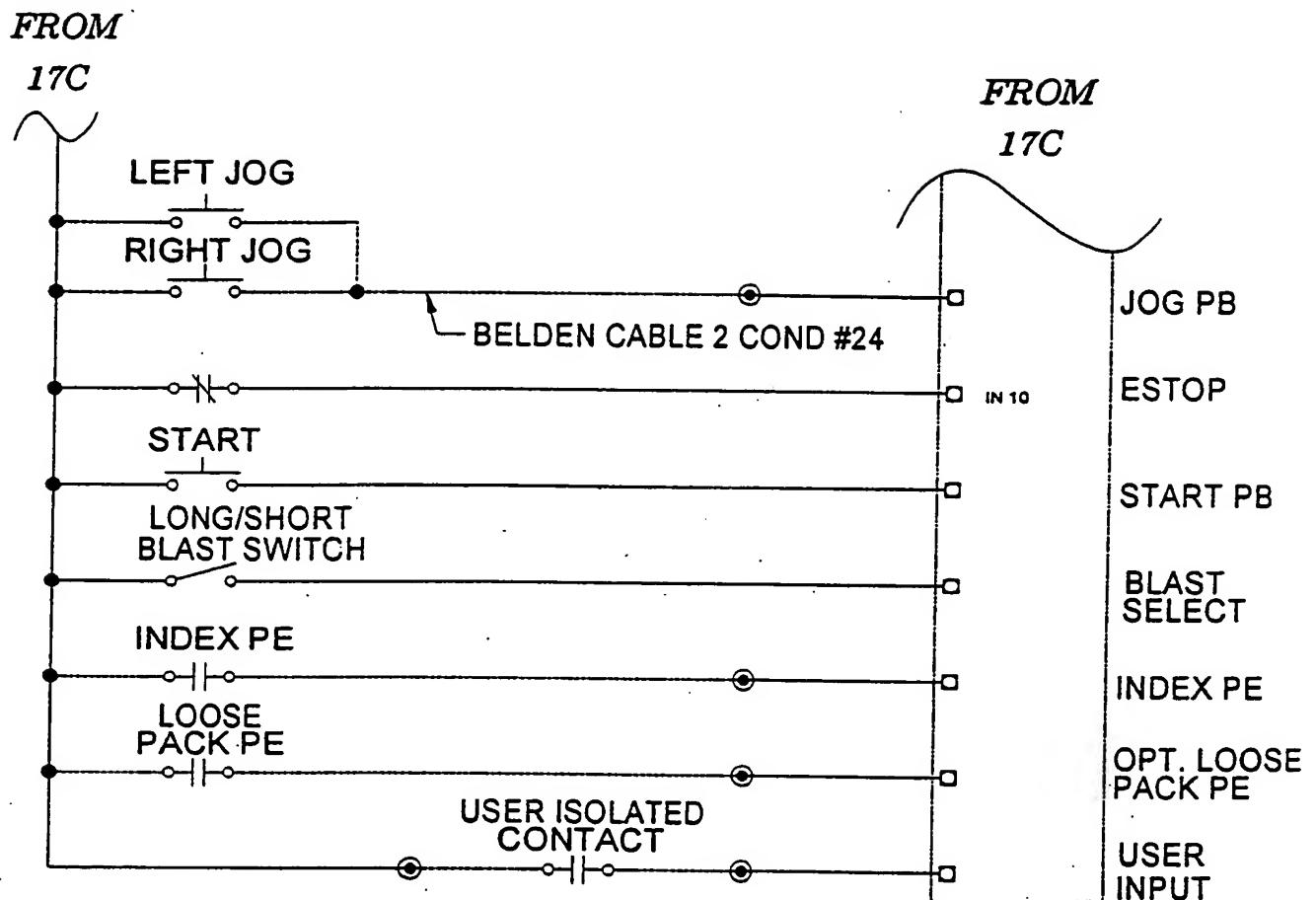


Fig. 17D

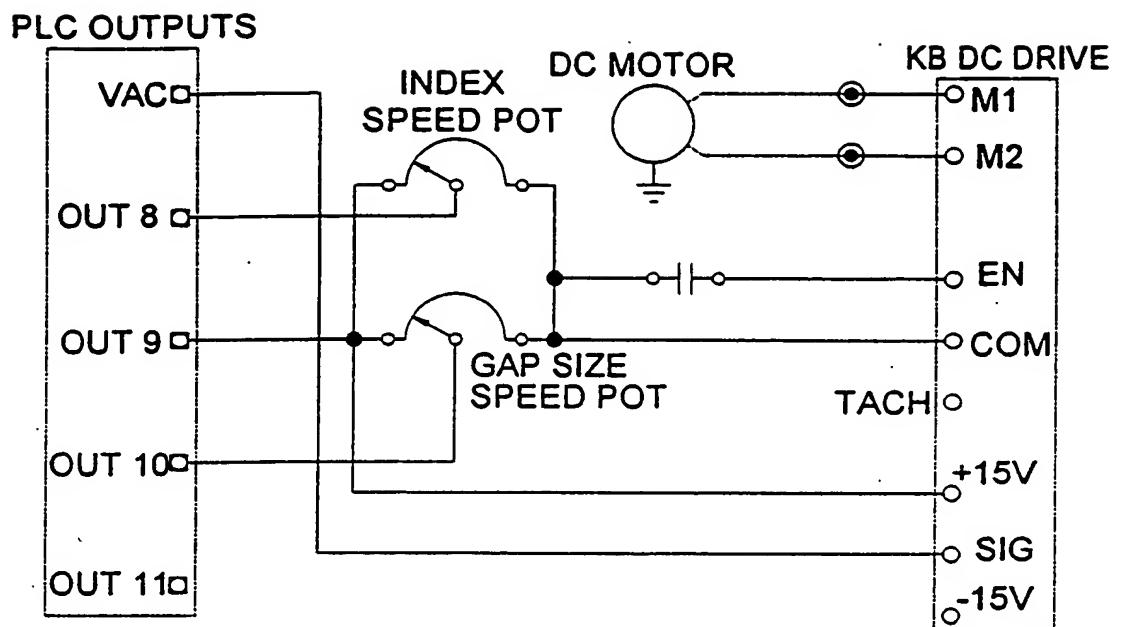


Fig. 17E

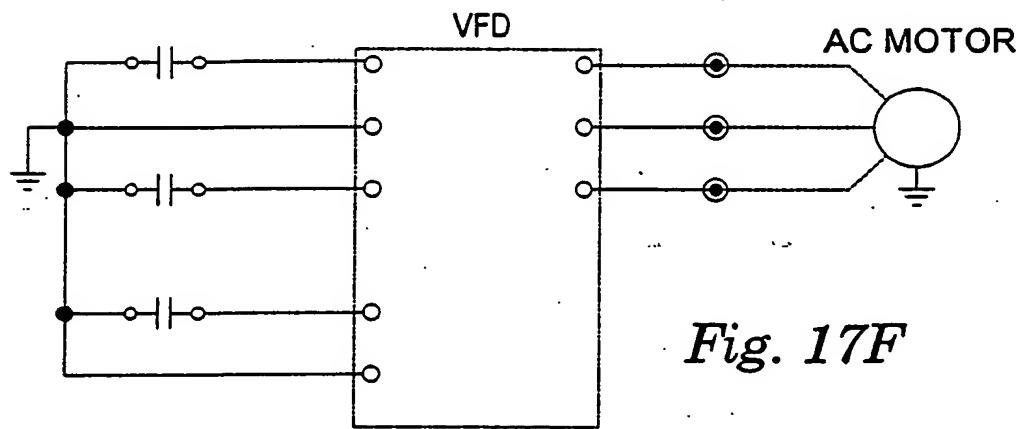


Fig. 17F

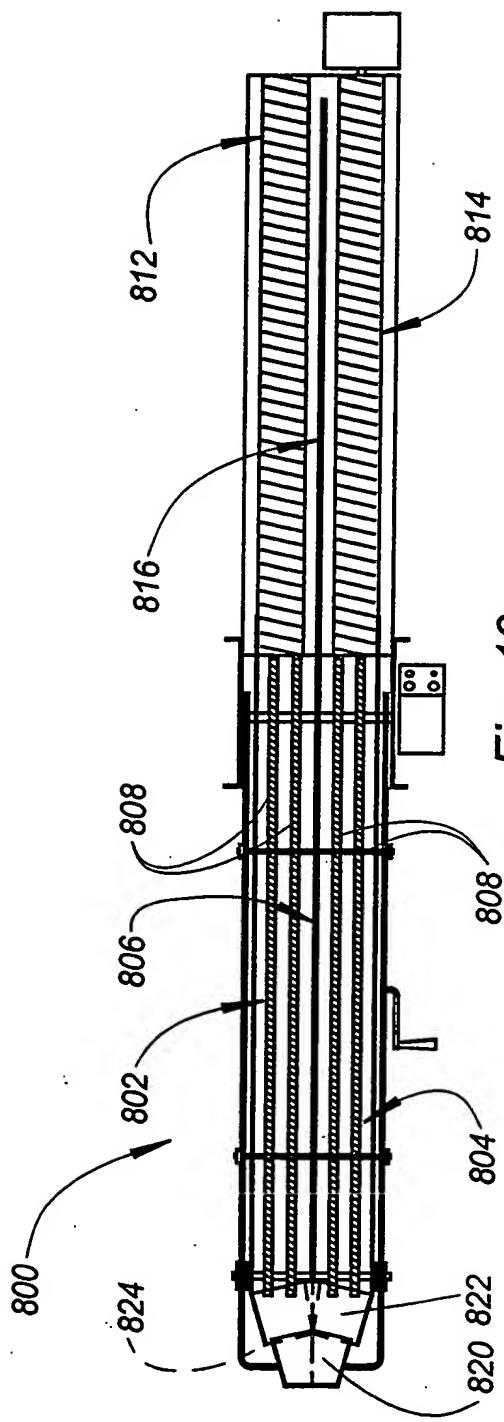


Fig. 19

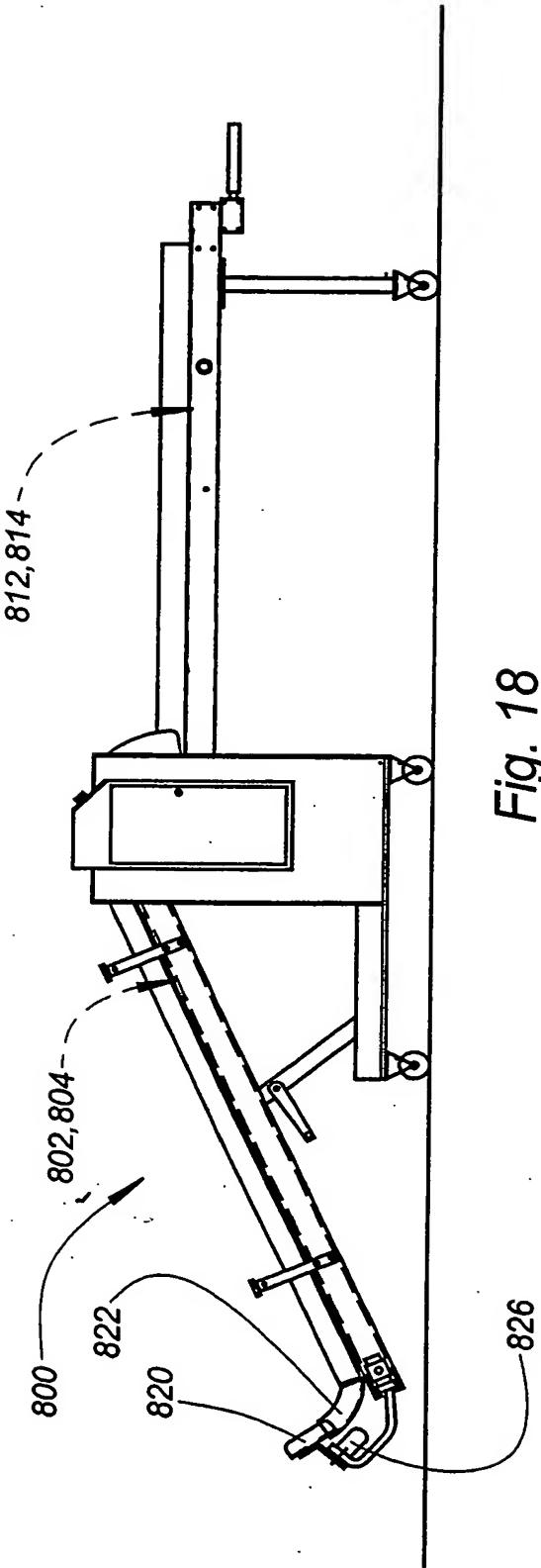
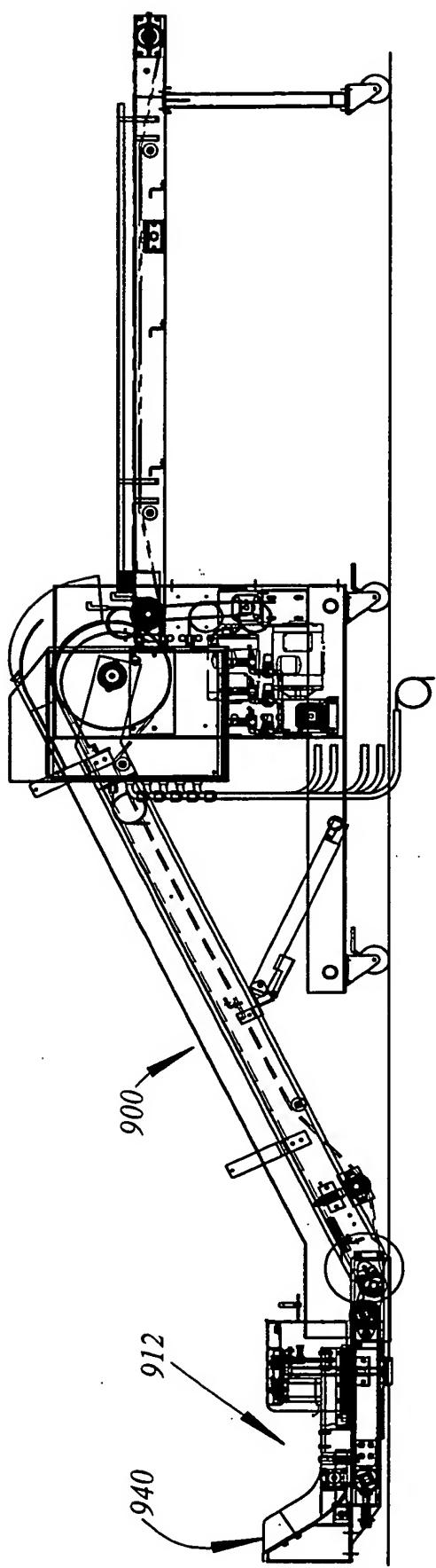
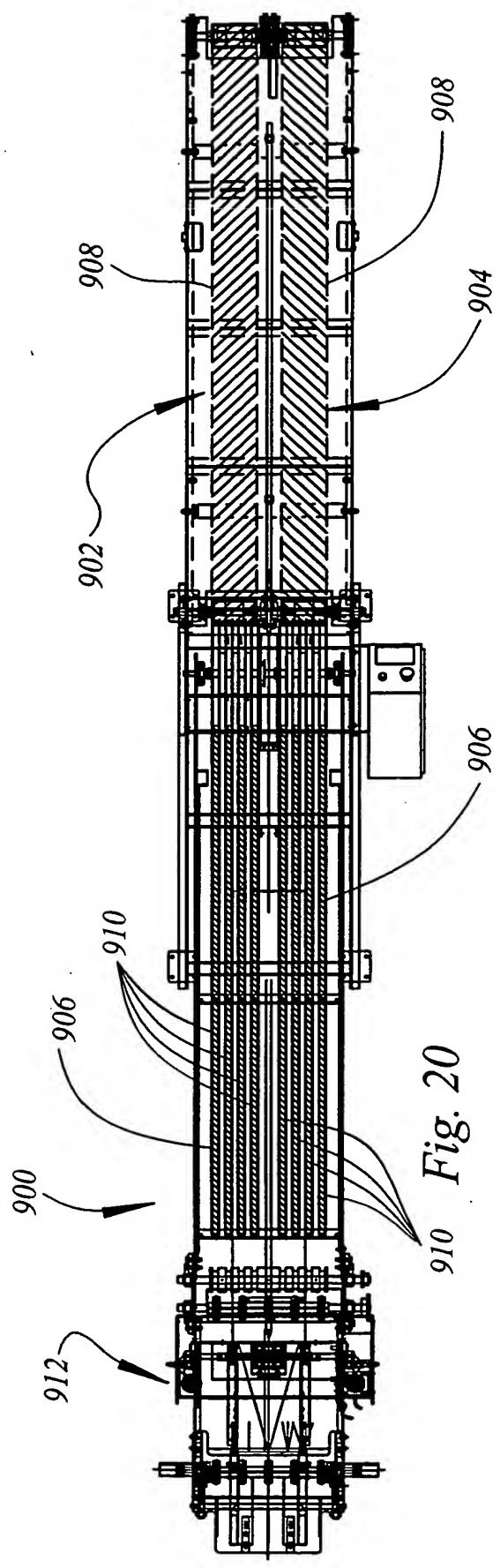


Fig. 18



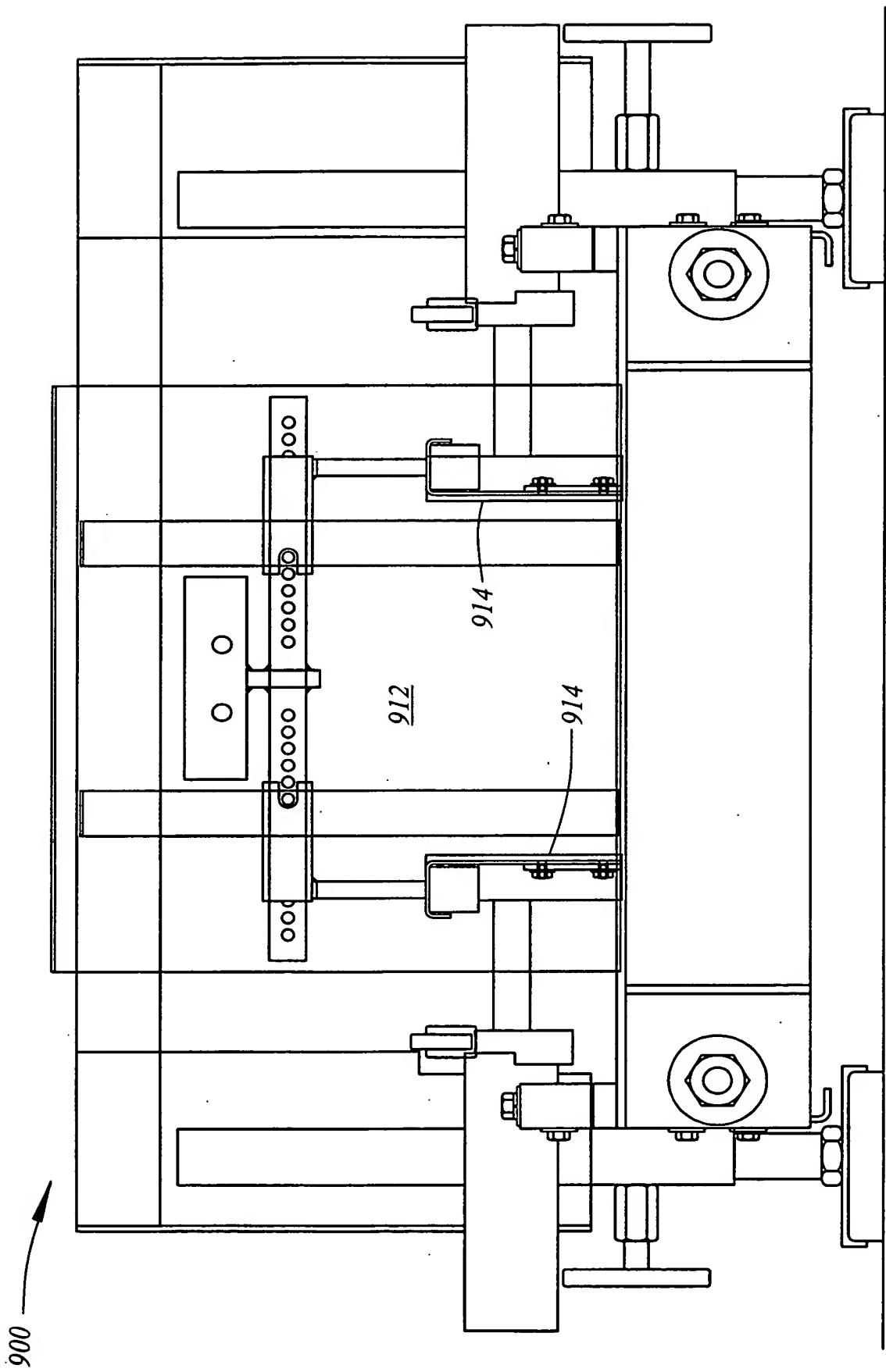


Fig. 22

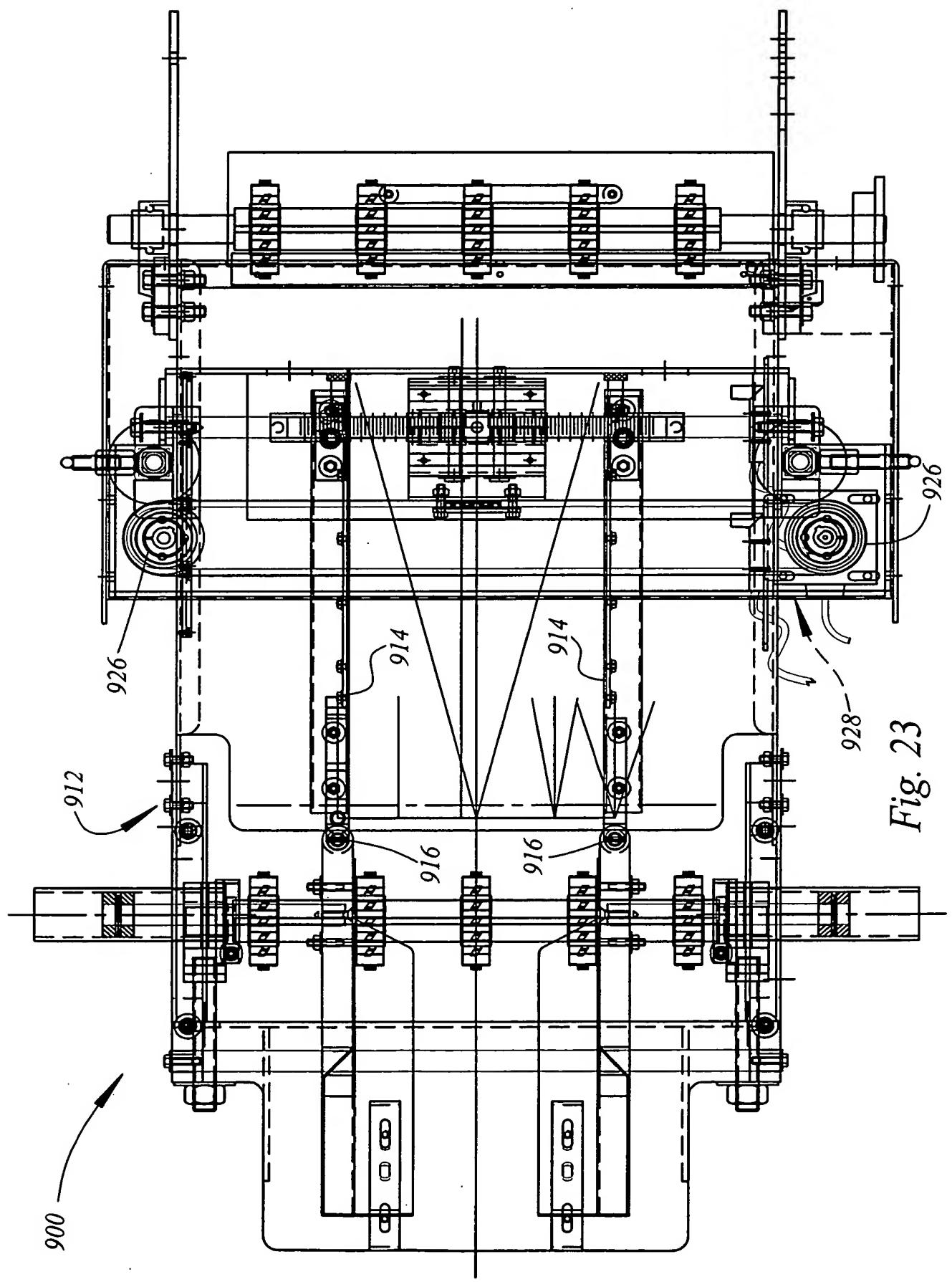


Fig. 23

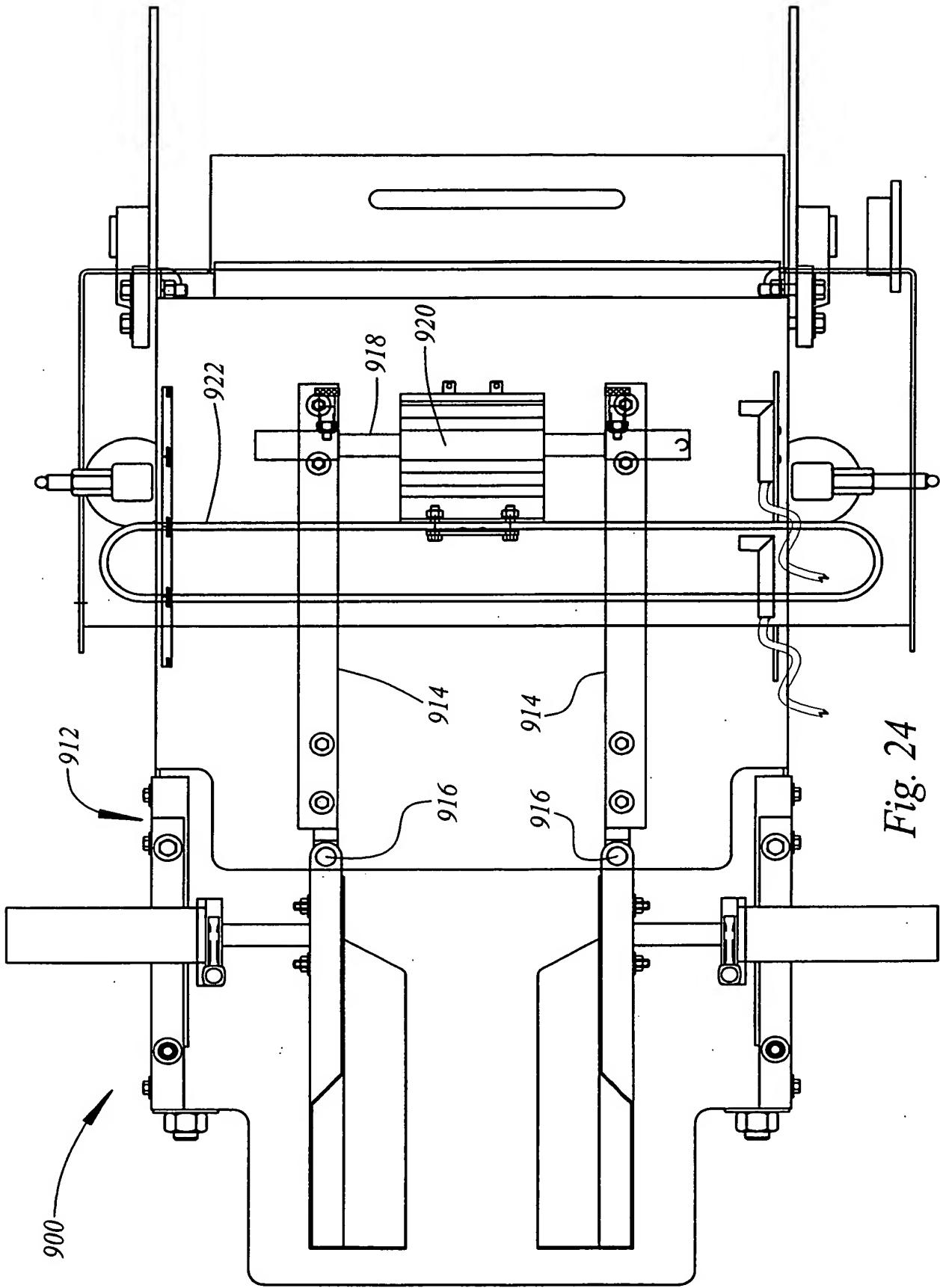


Fig. 24

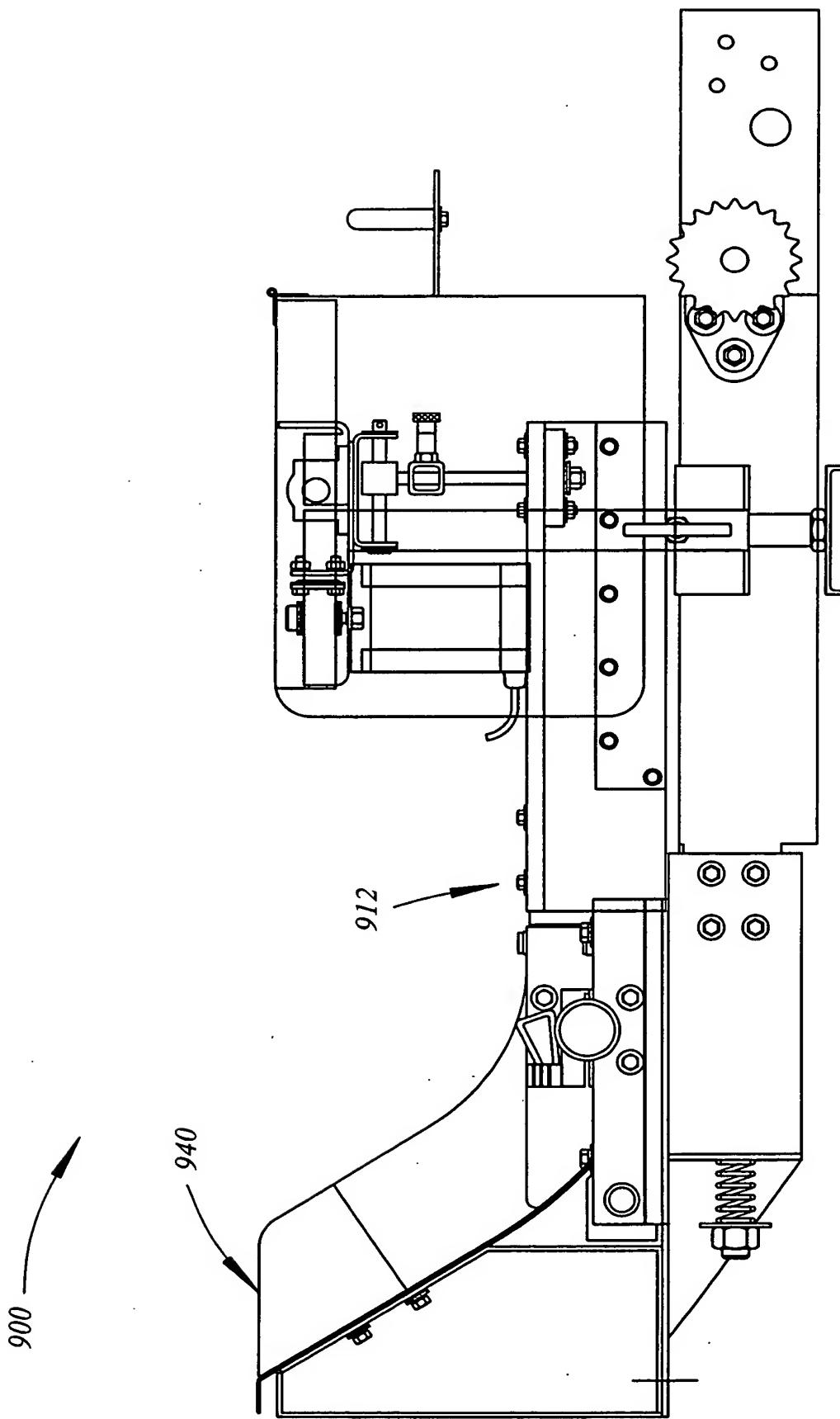


Fig. 25

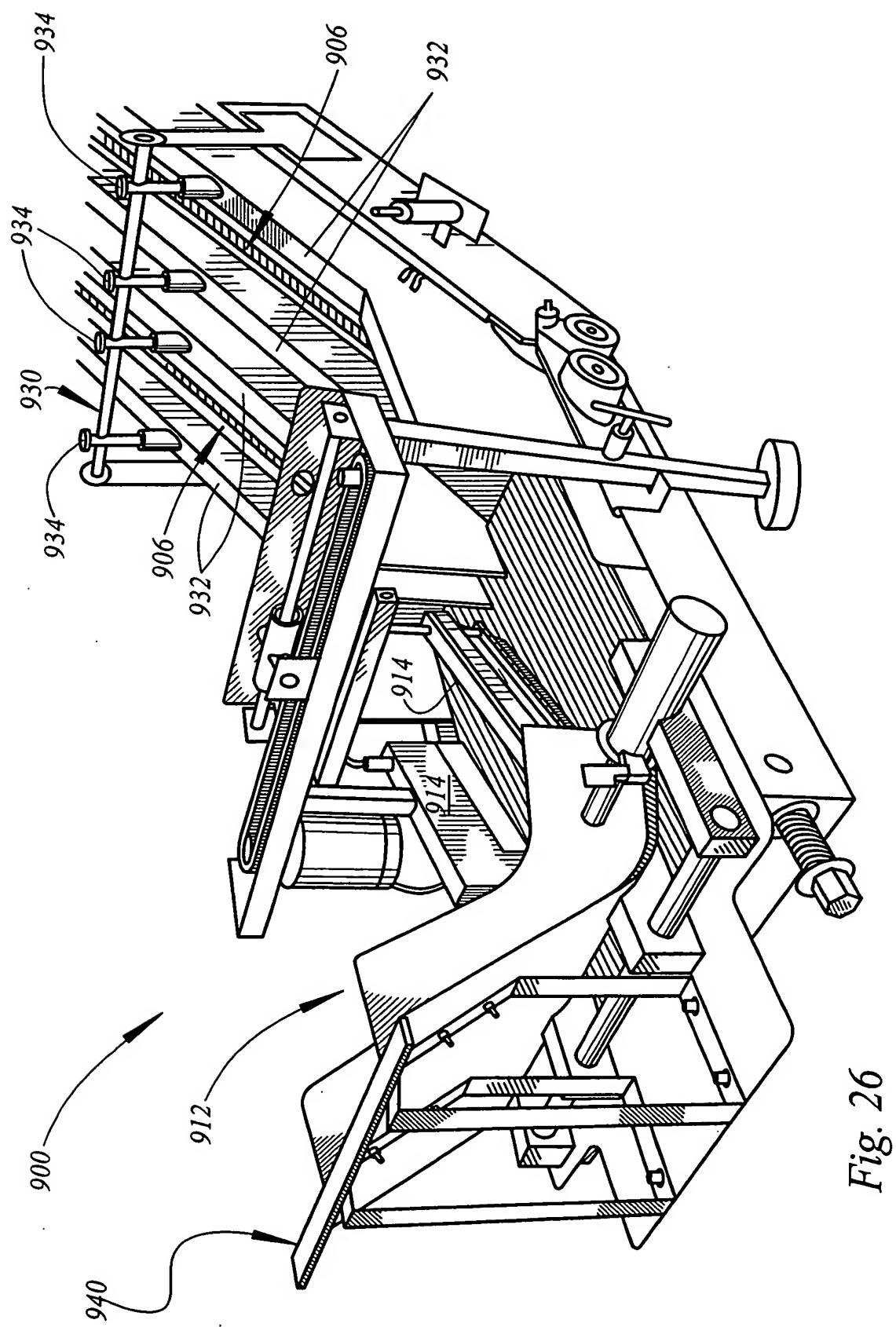


Fig. 26

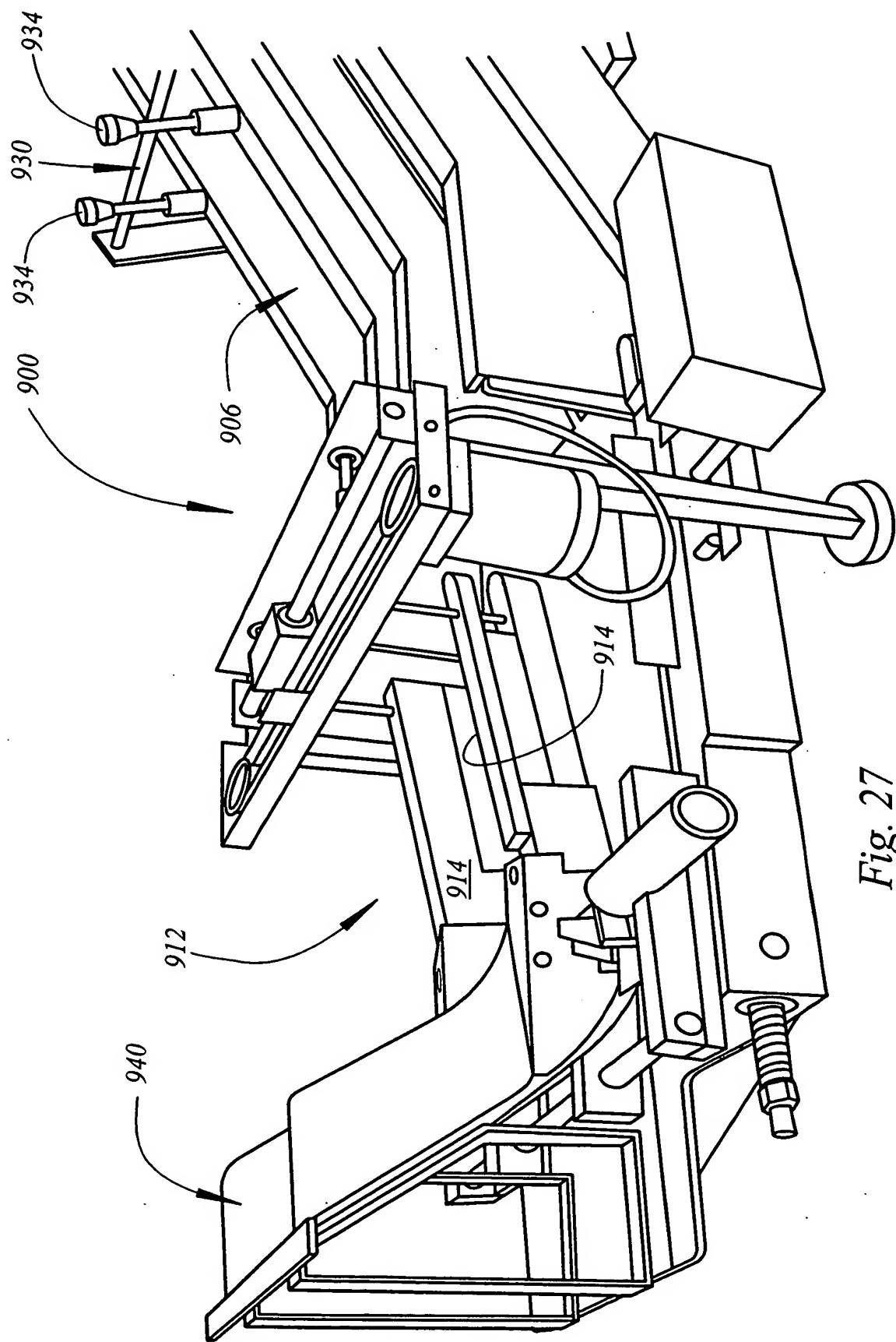


Fig. 27

900

Fig. 28

